

Lyon, Conklin & Co., Inc.
RACE & McCOMAS STS.
BALTIMORE 30, MD.

PEXTO

**Tentative Offering
October 1947**

MACHINES & TOOLS

*For Modern Sheet-Metal
Fabrication*



Booklet No. 139A

THE PECK, STOW & WILCOX COMPANY

— Since 1785 —

SOUTHINGTON, CONNECTICUT, U.S.A.

TENTATIVE OFFERING

**Where an asterisk (*) appears
THE ITEM HAS BEEN TEMPORARILY
DISCONTINUED.**

MACHINES and TOOLS FOR SHEET-METAL WORKING

for SHEET-METAL SHOPS and
INDUSTRIAL USERS.

PEXTO —



The Plant Behind PEXTO PRODUCTS

Since 1785 the history of The Peck, Stow & Wilcox Company has paralleled the technique of sheet-metal fabrication. The equipment listed in these pages represents the most advanced and efficient practice, developed against a background of practical experience and manufacturing facilities. The PEXTO trademark has long been accepted by experienced users as a guarantee of excellence in design, workmanship and performance.

These pages cover only a selection of machines and tools which have found wide application in sheet-metal shops and industrial plants handling the lighter type of work.

If your production requires the use of special purpose Machines and Tools not covered in the following pages, please write us. Our Engineering Department is always at your service.

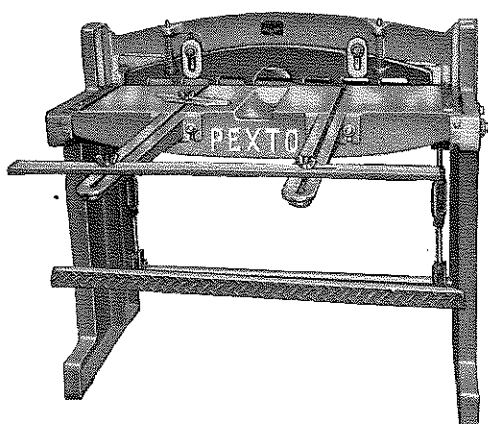
THE PECK, STOW & WILCOX COMPANY

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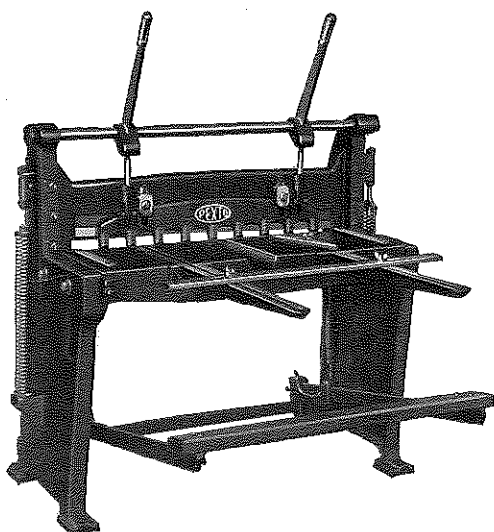
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For straight shearing of sheet steel, copper, brass, aluminum, lead, zinc and other materials. Encased compression springs practically eliminate spring breakage. Precision back gauge with graduated back gauge rods and heavy truss rod of cross-head for maintaining alignment of knives, assure accurate shearing at all times.

Front and back gauges and side gauge equipment are standard on all numbers. Hold down not furnished on No. 132.

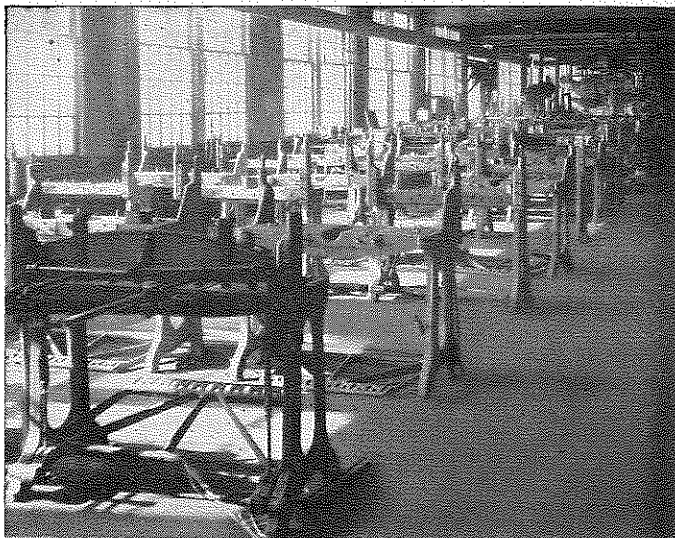
Number	132	137	142	152
Capacity mild steelgauge	18	18	18	18
Nominal cutting lengthins.	30	36	42	52
Shipping weight on skidslbs.	540	650	785	1030



These heavy patterns are recommended for shearing up to 16 gauge mild steel or equivalent. Powerful lever actuated hold-down clamps material securely. Long compression springs, truss rod on back of crosshead, steel treadle rods, precision back gauge, front and side gauges are standard equipment on all numbers.

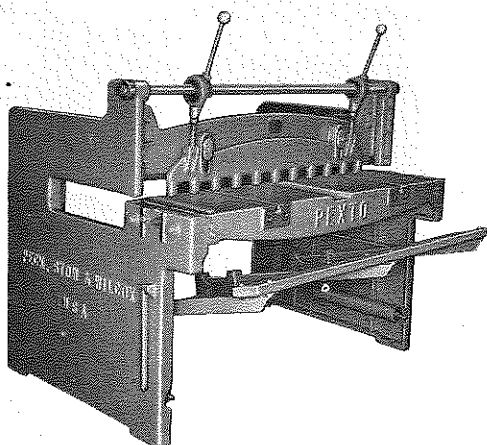
For continuous heavy shearing of 16 ga. and heavier we offer a complete line of Power Shears. Bulletin on request.

Number	*0236	*0242	0252
Capacity mild steelgauge	16	16	16
Nominal cutting lengthins.	36	42	52
Shipping weight on skidslbs.	1150	1250	1450



ONE OF THE PEXTO ASSEMBLY BAYS

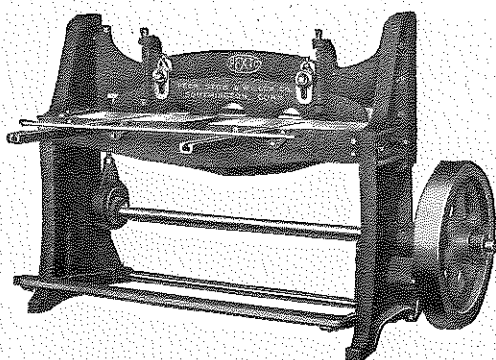
The PEXTO nameplate on Sheet-Metal Working Machines and Tools in your shop is of special significance to you as a Sheet-Metal Fabricator or Machinery Dealer. It is a guarantee that PEXTO equipment is backed by the resources of a major manufacturer who has constantly kept pace with developing needs in this industry, and whose very extensive plant facilities assure the long-range safety of your investment.



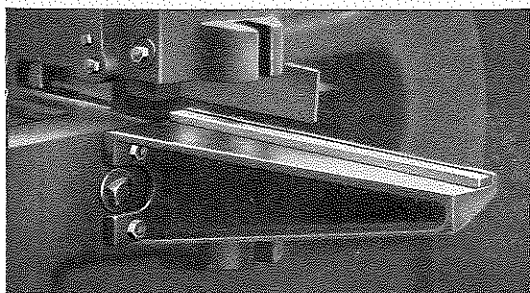
Where floor space is limited, and for economy, these shears have proved very popular because, in addition to cutting sheet metal up to the length of the knives, the gap-in-housing feature permits slitting a sheet of any length by successive cuts, feeding the material from left to right thru the housings.

Precision back gauge and front gauge equipment, adjustable side slitting gauge and lever actuated hold down are standard equipment.

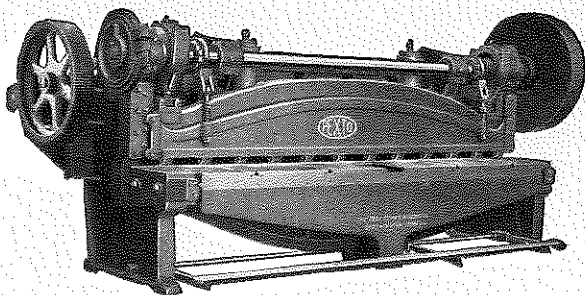
Number	*G36	G42	G52
Capacity mild steelgauge	16	16	16
Nominal cutting lengthins.	36	42	52
Depth of gap in housingsins.	18	18	18
Shipping weight on skidslbs.	1625	1850	2075



Underdriven Pattern

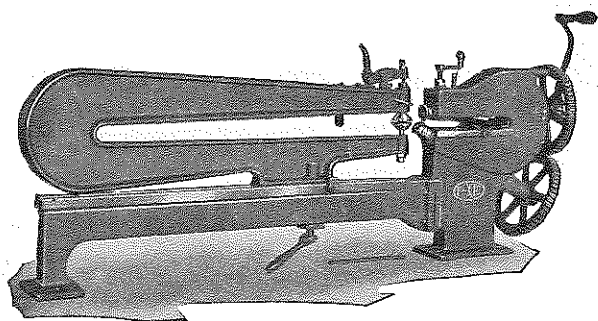


**PEXTO Overdriven Patterns can be furnished
with deep gap in the housings**



Overdriven Pattern

Bulletin on request.

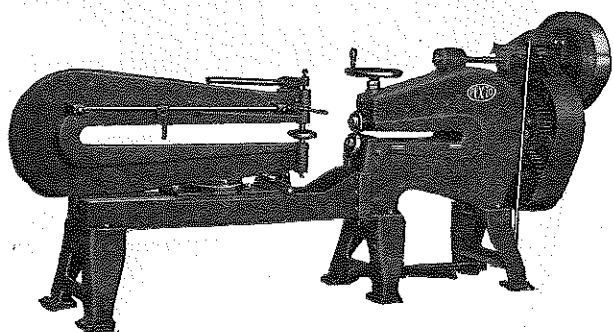


Ring and Circle Shears are used for cutting inside and outside circles in sheet metal of all kinds, cardboard, fibreboard, asbestos, insulating or similar materials used for gaskets.

Graduated scale on bed enables operator to quickly adjust clamping head for desired diameter of circle and eccentric lever on clamping head provides quick insertion and removal of blanks.

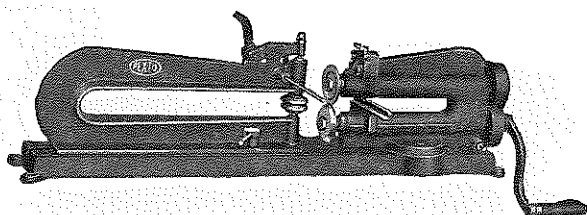
Arrangement details for motor drive on request.

Number—Hand	298	299
Capacity mild steelgauge	20	20
Depth cutting headins.	10	10
Depth clamping headins.	16¼	30½
Will circle from square blanksins.	3¼ to 22	3¼ to 42½
Shipping wgt. crated, handlbs.	215	275



For outside and inside shearing of sheet metal, PEXTO offers a line of Power Ring and Circle Shears up to 18" capacity for belt or individual motor drives.

Complete specifications, illustrations and quotations will be gladly submitted on receipt of details as to kind and thickness of material to be cut, also minimum inside and maximum outside diameter of circle.

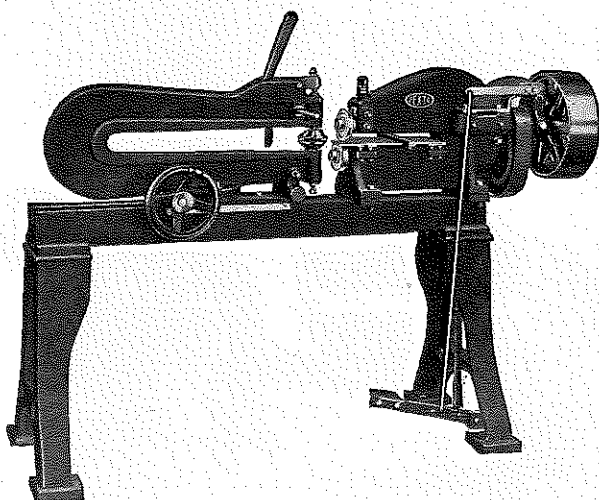


No. 278

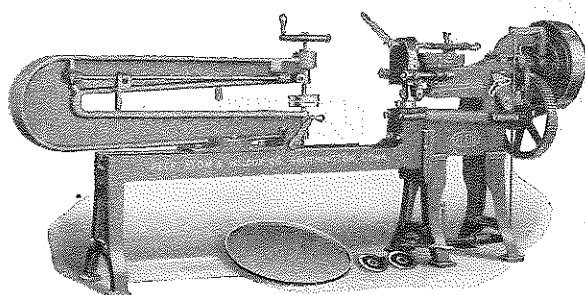
Circle Shears are intended for cutting outside circles, circular arcs and by removal of clamping head can be used for slitting sheet metals. Cutters are adjustable for wear and grinding. Eccentric clamping head and graduated scale on bed provide for quick insertion and removal of material.

Where required power operated details will be given on request.

Number	Hand *278	Hand X280
Capacity mild steel	22	18
Depth cutting head	10 $\frac{1}{4}$	10 $\frac{1}{4}$
Depth clamping head	16 $\frac{1}{4}$	34 $\frac{1}{2}$
Will circle from square blanks	2 $\frac{3}{4}$ to 22	3 to 48
Shipping weight boxed	140	
Shipping weight crated		350



Power Circle Shears for outside circular cutting can be furnished in capacities up to $\frac{1}{8}$ inch mild steel 76 inches in diameter, belt driven or for individual motor drive with or without friction clutch. These shears can also be furnished without clamping head and clamping head base for straight slitting long sheets. When so made are more commonly called Rotary Slitting Shears. Write for complete specifications and illustrations.



Height of flange which can be formed depends largely on thickness of material. The lighter material the less the height of the flange which can be formed. For capacities see following table.

Can be furnished as a Circle Shears without Flanging Attachment if required.

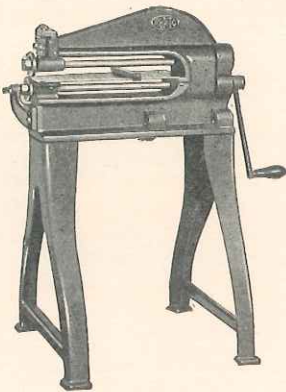
Shipped on skids	weight approx. lbs.	3000
Horse power required	approx. h.p.	3—1200 r.p.m.
Will cut in thickness or lighter	gauge	$\frac{1}{8}$
Depth of cutting head to frame	ins.	16 $\frac{1}{2}$
Depth of circle arm	ins.	38 $\frac{1}{2}$
Will circle from square blank with standard circle arm	dia. ins.	14 up to 53
Will flange in diameter	dia. ins.	16 up to 72
Maximum height of flange	ins.	1 $\frac{1}{2}$

Capacity

Thickness of Soft Steel	Max. Flange	Thickness of Soft Steel	Max. Flange
10 gauge	1 $\frac{1}{2}$ inch	16 gauge	1 $\frac{1}{8}$ inch
12 gauge	1 $\frac{3}{8}$ inch	18 gauge	1 inch
14 gauge	1 $\frac{1}{4}$ inch	20 gauge	$\frac{7}{8}$ inch
		22 gauge	$\frac{11}{16}$ inch

*Further details on request.

Rapidity of operation and strength are characteristic of PEXTO machines. Built for maximum power and to give efficient service, to last indefinitely with proper use and care.

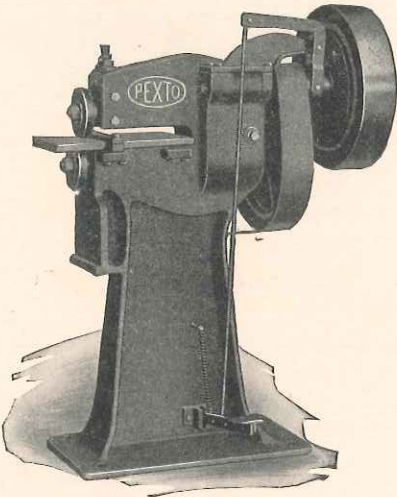


An inexpensive substitute for the Long Length Squaring Shear where floor space is limited. Depth of cutting head permits slitting the center of a 36 inch wide sheet.

Fitted with supporting table and gauge.

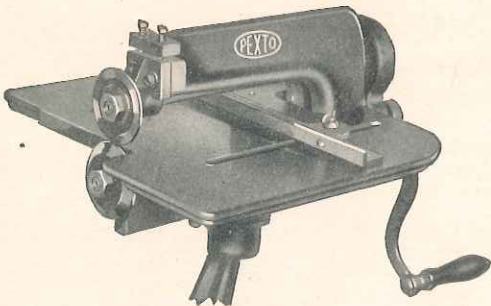
Number	255
Capacity	gauge 16
Depth cutting head to gauge	ins. 18
Diameter of cutters	ins. 3 1/8
Shipping weight crated	lbs. 350

*POWER SLITTING SHEARS



Will cut up to, thickness	ins. 1/8	1/8	1/8	1/8
Cutting head, depth	ins. 13	20	31	16 1/2

BENCH ROTARY SHEARS

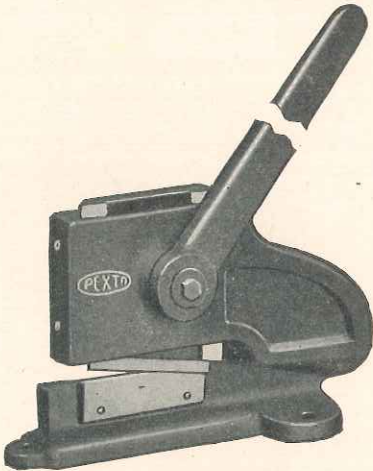


A compact shears for light trimming and slitting. Inexpensive, durable and practical.

Furnished with No. 975 Bench Standard.

Number	250
Capacity mild steel	gauge 20
Diameter cutters	ins. 3
Cutting head depth	ins. 9½
Cutting head depth to gauge	ins. 9
Shipped boxed	approx. lbs. 110

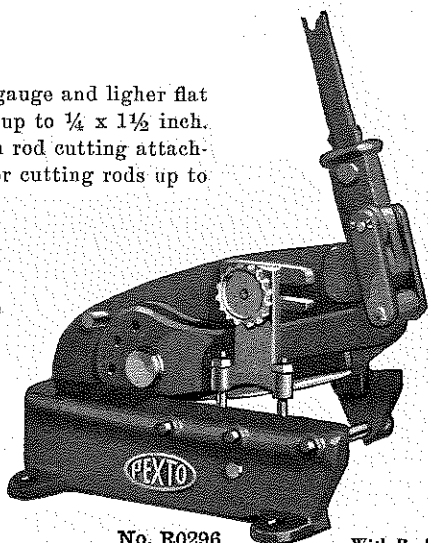
CUT OFF SHEARS



An inexpensive shears that may be used as a cut off or slitting shears. Its eccentric cutting device requires little effort when cutting up to the maximum capacity.

Number	253
Capacity mild steel	gauge 16
Length of cut	ins. 3½
Length overall including lever	ins. 18
Weight	approx. lbs. 17

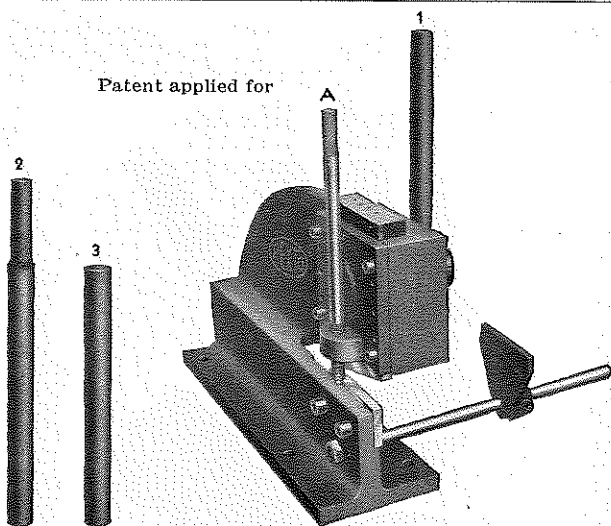
For slitting 10 gauge and lighter flat sheets or band iron up to $\frac{1}{4} \times 1\frac{1}{2}$ inch. When equipped with rod cutting attachment can be used for cutting rods up to $\frac{1}{2}$ " diameter. Frame is steel casting and blades high carbon steel laid. Hold-down and adjustable gauge is provided.



No. R0296

Number		With Rod Cutter	
		*0296	*R0296
Capacity mild steel	gauge	10	10
Length cut	ins.	7 $\frac{3}{4}$	7 $\frac{3}{4}$
Shipping weight boxed	lbs.	175	180

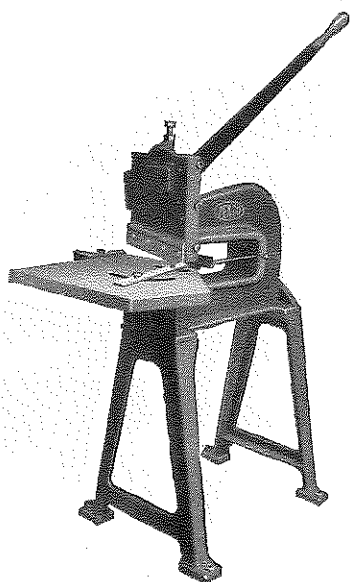
Patent applied for



Number		0325
Capacity—mild steel for slitting	ins.	$\frac{3}{8}$
Capacity—mild steel for trimming	ins.	$\frac{1}{4}$
Capacity—bar iron	ins.	$\frac{1}{8} \times 2$
Length cutting blades	ins.	4 $\frac{1}{2}$
Depth of gap	ins.	2
Depth of throat	ins.	9
Length gauge rod	ins.	14 $\frac{1}{2}$
Shipped boxed regularly	weight approx. lbs.	140

Frame welded steel construction. Blades high carbon steel laid. An easy working principle for all shearing up to the full rated capacity of the machine is contained in a lever eccentric operating a slide to which the upper blade is attached. With these shears there can be no wedging of the iron as a hold-down (A) is provided. The design of the frame allows the sheet to pass without obstruction and is fitted with adjustable gauge. Three levers are provided: (1) Fitted permanently, for light shearing. (2) Fits over (1) for shearing where increased leverage is desired. (3) Fits over (2) and by combining the three a lever 36" overall length eases the cutting up to capacity.

UTILITY LEVER SHEARS



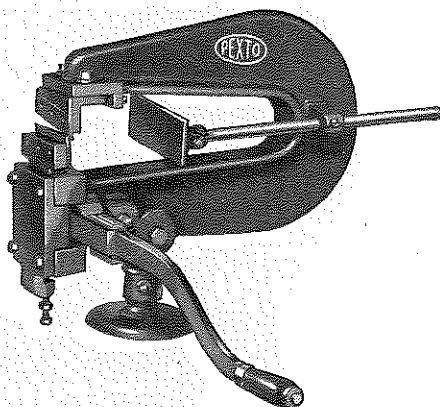
For slitting and irregular inside and outside cutting.



Illustrations of work cut from blanks to line.

Number	Bench *248	Floor Legs 241
Capacity mild steel	18 gauge	12
Length of cut	6½ ins.	9
Cutting head, depth	10 ins.	19½
Cutting head, depth to gauge	9½ ins.	18½
Size of table	12x15½ ins.	16x20
Shipped boxed	150 approx. lbs.	
Shipped crated		520 approx. lbs.

SCROLL SHEARS



Number	269
Capacity mild steel	20 gauge
Length of cut	4½ ins.
Cutting head, depth	18½ ins.
Cutting head, depth to gauge	17 ins.
Shipped boxed	150 approx. lbs.

For slitting and irregular cutting similar to above illustrations.

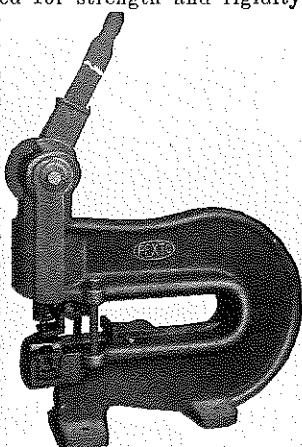
For punching holes near center of sheet these punches have a 15" throat without stay bolts and a 3½" throat with stay bolts in place. They are designed for strength and rigidity making them exceptionally useful machines for general work.

⅛", ⅜", ½" punch and die included with No. 675. ¼", ⅝", ¾" punch and die included with No. 676.

Special size punches and dies quoted upon application.

Number	*675
Cap. with stayboltsga.	9
Cap. without staybolts..ga.	12
Shipping weightlbs.	160

Number	676
Cap. with staybolts ⅝" in ⅞" iron	
Capacity without staybolts ⅝" in ⅞" iron	
Shipping wgt., lbs.	260



COMBINED PUNCH AND SHEAR

Number	*679
Capacity punching. ⅜" hole in ⅞" iron.	
Capacity shearing. 14 gauge soft steel and lighter or ⅞" x 1" bars.	
Furnished with ⅛, ⅜, ½, ⅝, ¾ inch punches and combination die.	
Length cutins.	4¾
Depth punching gapins.	2¾
Shipping wgt.lbs.	140



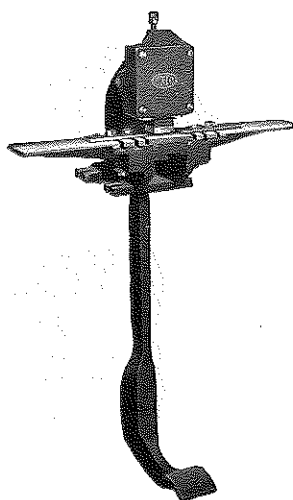
Number	680
Capacity for punching ⅝" hole in ⅞" iron	
Depth of punching gap....ins.	5
Will centersheetswidth ins.	10
Capacity for shearing, will cut sheet iron gauge No.	8
Lgth. of cut.ins.	6
Will cut bar ironins. ¼x1¼, ⅜x¾ or ½" sq.	
Shipped crated regularly, wgt.approx. lbs.	400



NOTE—Furnished regularly with three dies and punches; viz.: ¼, ⅝, ¾ inch.

*Temporarily Discontinued

FOOT NOTCHING MACHINE



This machine is a real time-saver for notching corners or the edge of sheet. Lower die is made in three sections and can readily be replaced with special shaped dies.

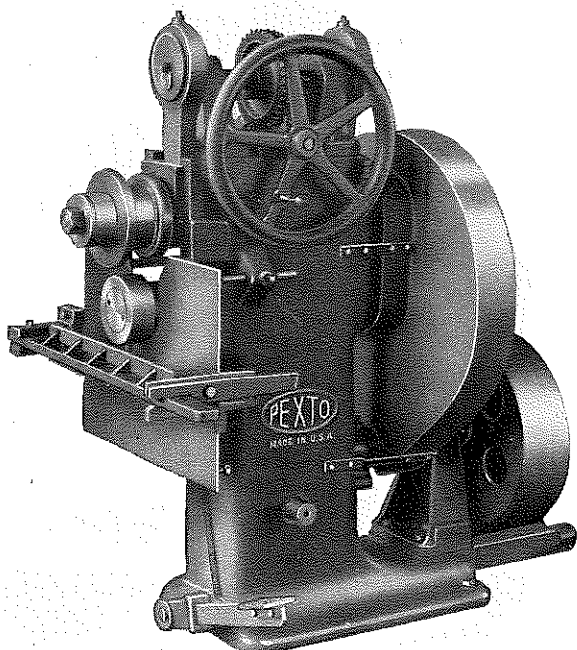
NOTE:—Furnished complete with 2" x 2" punch and die and full equipment of gauges. Special dies quoted on application.

Furnished regularly for bench use which requires a cutout in bench.

Number	737
Capacity	gauge 20
Size die	ins. 2 x 2
Shipping wgt.	lbs. 200

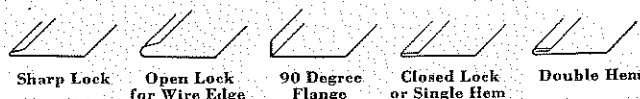
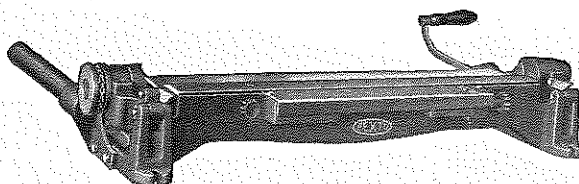
For square, Rectangular and V notches.

SPECIAL MACHINERY



Designed for Special Beading and numerous Rotary Operations. The PEXTO line of Special patterns is unusually complete.

ADJUSTABLE BAR FOLDER



Adjustable Bar Folders will form sharp locks on edge of sheet metal for double seam, open locks for wired edges, flanges of various degrees, and single or double hems.

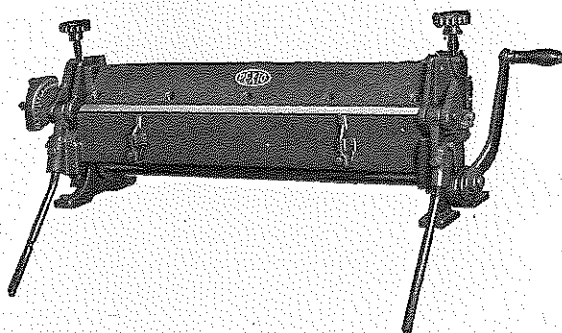
Adjustable stop is provided to permit the forming of any desired angle.

Unusually long four bearing gauge with steel teeth, conveniently located hand screw for locking gauge after setting, hardened edge bevel blade, new design counter-balance, adjustable for varying tension, perfectly balancing the folding bar for greatest ease in operation, are features that appeal to the experienced sheet metal worker.

Minimum folds $\frac{3}{16}$ " on 22 ga., $\frac{1}{8}$ " on 24 and $\frac{3}{32}$ " on 28 ga.

Number	62	63	055
Folding length	20	30	36
Capacity mild steelmax. gauge	22	22	20
Gauging range	$\frac{1}{8}$ to 1	$\frac{1}{8}$ to 1	$\frac{1}{8}$ to 1 $\frac{1}{4}$
Round folds for wiremax. dia. ins.	$\frac{1}{4}$	$\frac{1}{4}$	$\frac{3}{8}$
Shipping weight boxed	150	260	420

COMBINATION FOLDER AND BRAKE



Embodying features of the Hand Brake and Bar Folders, the Combination Folder and Brake is a handy machine in any shop.

Metal passes under clamping bar from front to back as on a brake. Clamping bar can be raised one inch, sharp beveled blade, adjustable folding bar for open locks, front disappearing gauges, back gauge and quadrant gauge are standard equipment. Floor legs can be furnished at extra cost.

Minimum folds $\frac{3}{16}$ " on 20 gauge, $\frac{1}{8}$ " on 24 gauge.

Number	697
Capacity mild steelmax. gauge	20
Length for sheets	42
Shipping weight crated	525

Rochester, N. Y.

We wonder if it would be interesting to your people to know that this Company has been using your PEXTO Machines in our Lantern Shops for fifty-six years.

I know whereof I speak because I have been with this Company fifty-three years and have myself personally, years ago, handled everyone of these Tools.

The Tools such as the Burring Machines, Setting Down Machines, Folders, Double Seamers, etc., especially the Square Shears, have all given the greatest of satisfaction and it is remarkable in these times the durability that we have noticed from these Tools.

We have tools of your make here over fifty years and still being used. The first fifty years were the hardest.

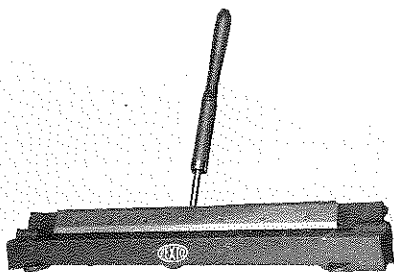
STAR HEADLIGHT & LANTERN CO.

Very truly yours,

By (signed)

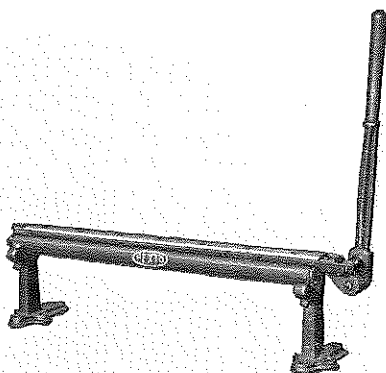
A.W. Jacobs

SHEET IRON FOLDER



Number		*10	*15
Capacity soft steel and lighter	gauge	22	24
Length for sheets	width ins.	30	42
Will form locks	ins.	$\frac{1}{4}$ to $\frac{1}{2}$	$\frac{1}{4}$ to $\frac{1}{2}$
Shipped boxed regularly	weight approx. lbs.	90	140

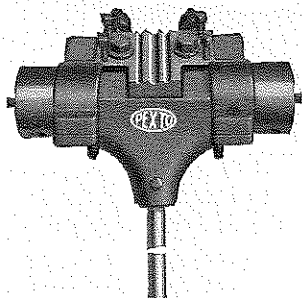
CHAMPION PIPE FOLDER



For folding the edges for the side seams of round pipe, after being formed, as well as for folding the edges of straight sheets.

Number		*11
Capacity soft steel and lighter	gauge	24
Length for sheets	width ins.	30
Will form locks	ins.	$\frac{1}{8}$ to $\frac{3}{8}$
Shipped boxed regularly	weight approx. lbs.	105

BRACE AND WIRE BENDER

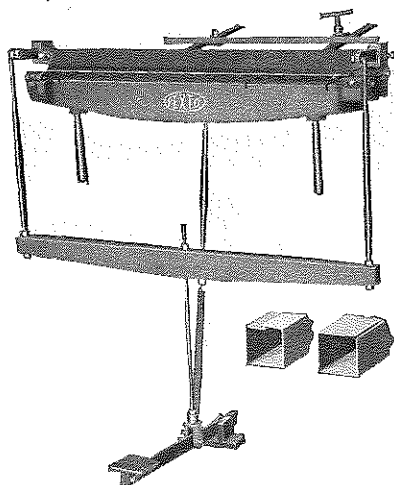


For making braces for look-outs, gutters, leaders, cornices, etc. It will bend iron of any size up to $\frac{1}{4}$ -inch thick, 2 inches wide from 0 to 90 degrees. The top plate is adjustable for turning sharp or round corners and for different thicknesses of metal, regulated by means of the hold-down and set screws in the top plate and set screws at the back of the plate. One side of the top plate is cut with grooves in several sizes, and when reversed, wires can be bent for pans, boxes, etc.

Number		402
Width of bending plate	ins.	2
Will form wire	diameter ins.	$\frac{3}{8}$
Size of half round grooves in top plate	ins.	$\frac{1}{8}$ - $\frac{3}{8}$ - $\frac{1}{2}$ - $\frac{3}{4}$
Shipped boxed regularly	weight approx. lbs.	50

NOTE:—Handle may be used in center or at either end of machine. When ordered for wire bending exclusively, a hardened steel plate is recommended and can be furnished at a minimum extra charge when so ordered.

PIPE, BOX AND PAN FORMERS

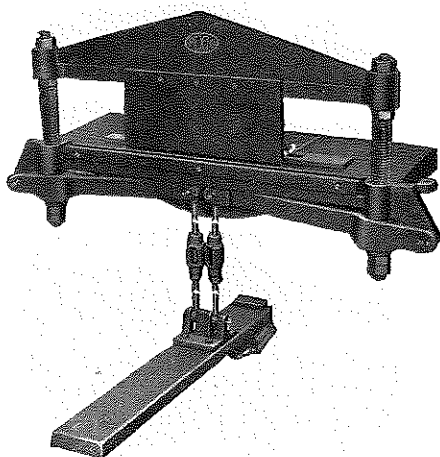


A machine of simple construction for forming the bodies of square and rectangular cans, heater pipe, boxes, etc., with either lapped or locked side seams. The work forms around the clamping bar. Sheets can be formed at right angles or less.

Number *434

Length for work	width ins.	36
Capacity soft steel and lighter	gauge	26
Smallest square pipe that can be formed	ins.	4
Shipped boxed regularly	weight approx. lbs.	175

PAN FORMING MACHINE



Adapted for forming flaring and straight work, but variations in the flare of pans, etc., necessitates an extra forming blade and die bed.

For each size of pan or box an extra forming blade is required.

Work can be formed as shallow as $\frac{1}{2}$ -inch and as deep as $5\frac{1}{2}$ inches. Length of die bed is 25 inches.

Number *436

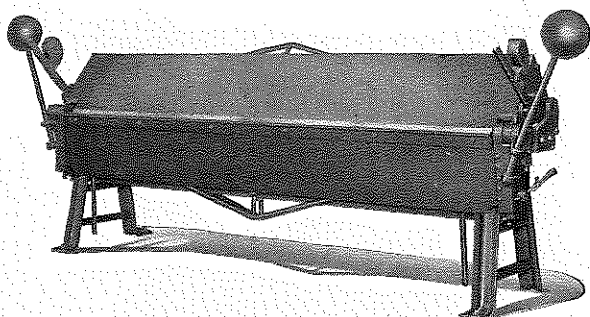
Length die bed	ins.	25
Capacity soft steel and lighter	gauge	24
Width bed plate	ins.	11½
Stroke	ins.	¾
Shipped boxed regularly	weight approx. lbs.	225

Furnished regularly with forming die and one blade length 13½ inches for forming 90° bends. Blades of special lengths and the following standard blades are extra.

Standard Steel Forming Blades

Length...ins.	8	10	12	14	16	18	20	22	25
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*Temporarily Discontinued

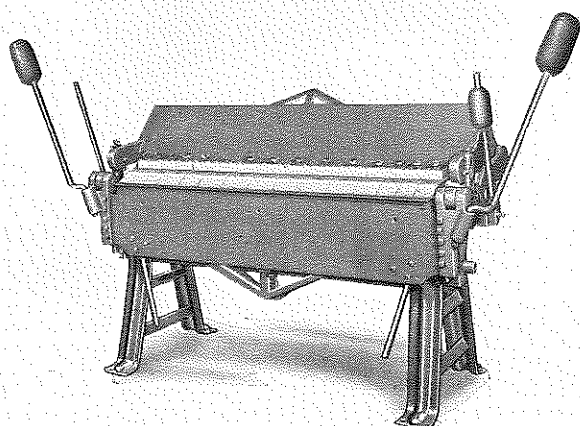


$\frac{1}{4}$ inch detachable steel bar on apron and angle bar for heavy bending are regular equipment. Five moulding formers, one each $\frac{7}{8}$, 1, $1\frac{1}{8}$, $2\frac{1}{4}$ and 3 inch and set of clamps can be furnished when specified at an extra charge.

Rated capacity is for bending 1 inch or wider flange in mild steel full length of machine. Proportionately narrower flanges can be formed on lighter gauges.

No.	Length Inches	Capacity	Wgt. Lbs.	No.	Length Inches	Capacity	Wgt. Lbs.
1109	36 $\frac{1}{2}$	12 ga.	940	1006	73	16 ga.	1135
1009	36 $\frac{1}{2}$	14 ga.	690	1001	73	18 ga.	820
1004	36 $\frac{1}{2}$	16 ga.	470	1112	97	12 ga.	2570
1110	48 $\frac{1}{2}$	12 ga.	1250	1011	97	14 ga.	2050
1010	48 $\frac{1}{2}$	14 ga.	810	1007	97	16 ga.	1470
1005	48 $\frac{1}{2}$	16 ga.	585	1002	97	18 ga.	1010
1102	61	12 ga.	1480	1012	121	14 ga.	3025
1101	61	14 ga.	1230	1008	121	16 ga.	2440
1100	61	16 ga.	1010	1003	121	18 ga.	2040
1080	61	18 ga.	710	1103	145	18 ga.	4275
1107	73	12 ga.	2015	1104	145	22 ga.	2745
1106	73	14 ga.	1625	Shipped on skids.			

CHICAGO BOX AND PAN BRAKES



Standard assortment of box and pan fingers is a combination of 3, 4 and 5 inch widths. By grouping these fingers any length from the 3 inch dimensions to the full length of machine can be obtained. Rated capacity is for bending 1 inch or wider flange in mild steel of the length of machine. Proportionately narrower flanges can be formed on lighter gauges.

Refer to page 21 for specifications.

See illustration page 20

CHICAGO UNIVERSAL HAND BOX
& PAN BRAKES

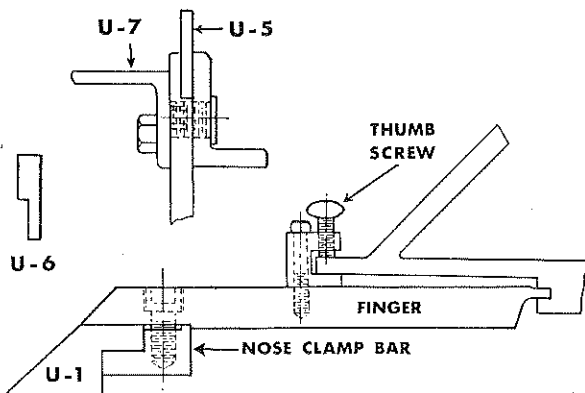
6" FINGER EXTENSION

Old No. Equivalents	New No.	Length	Capacity	Weight
....	L3000	3 feet	12 gauge	1315 lbs.
3000	W3000	3 feet	14 gauge	960 lbs.
....	L3100	4 feet	12 gauge	1700 lbs.
3001	W3100	4 feet	14 gauge	1252 lbs.
....	L3200	5 feet	12 gauge	2320 lbs.
3002	W3200	5 feet	14 gauge	1800 lbs.
....	L3600	6 feet	12 gauge	2550 lbs.
3006	W3600	6 feet	14 gauge	2030 lbs.
....	L3700	8 feet	12 gauge	3100 lbs.
3007	W3700	8 feet	14 gauge	2600 lbs.
....	W3800	10 feet	14 gauge	3750 lbs.
3008	R3800	10 feet	16 gauge	3200 lbs.

8" FINGER EXTENSION

Old No. Equivalents	New No.	Length	Capacity	Weight
3003	W3300	3 feet	14 gauge	1060 lbs.
3004	W3400	4 feet	14 gauge	1570 lbs.
3005	W3500	5 feet	14 gauge	1920 lbs.
3009	W3900	6 feet	14 gauge	2215 lbs.
3010	W4000	8 feet	14 gauge	2900 lbs.

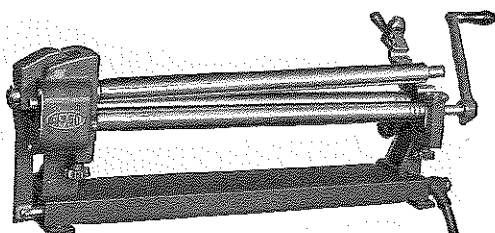
Standard equipment includes regular bending bars U1, U5, U6, angle bar U7, stop gauge and wrenches. Five moulding forms one each $\frac{5}{8}$ ", 1", $1\frac{5}{8}$ ", $2\frac{1}{4}$ ", 3" and set of clamps can be specified at an extra charge.



U1 Top nose bar
U5 Bending edge bar $\frac{1}{4}$ "

U6 Bending edge bar $\frac{1}{2}$ "
U7 Angle bar

2 INCH ROLLS



The lift type of Slip Roll Formers, as these new patterns offer, leaves free the hands of the operator for the feeding and removal of work. Ample clearance is provided at left end housing for removing work when formed full length of the rolls.

Lifting of the upper roll is effected through a lever on right end of machine always in easy reach of operator and locks automatically with the roll in tilted position. Simple and very easy to operate.

The rolls need not be stopped when operating the lifting device, a desirable feature especially when arranged power drive, an improvement that merits consideration. Rolls are high carbon steel, smoothly finished and ground.

Strength is assured through a patented hinged cap fitted to the right end housing which clamps in one motion and when clamped, it serves as a desirable support making a fully enclosed housing for the bearing of upper roll.

The compensating gears are solid steel machine cut always remaining in mesh and are fully enclosed. This permits for ample adjustment of lower roll for clearance so as not to cause the closing of locks previously formed on sheets. Positively no binding of gears while machine is run with upper roll in horizontal or in tilted position.

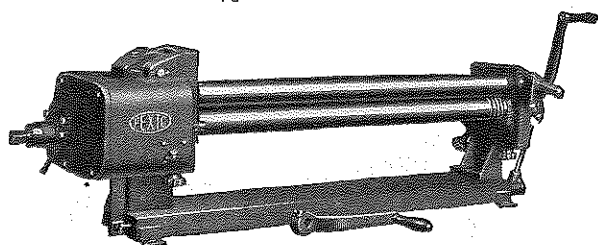
Housings are rigidly mounted on steel base. Rolls are ground and smoothly finished and are provided with a series of grooves for forming work that has been previously wired.

External grease cups are provided for idler gears in the gear case.

Number—Hand Drive	382	381	0381
Capacity mild steelgauge	22	22	24
Length of rolls for sheetsins.	30	36	42
Diameter of rollsins.	2	2	2
Shipping weight boxed, hand driveapprox. lbs.	230	250	270

NOTE:—Floor legs can be furnished at extra cost. Front upper and lower rolls are driven. At an extra cost can be furnished with all three rolls driven. When required motor drive or with pulleys, details will be given on request.

2½ INCH ROLLS



On these 2½ inch diameter rolls a convenient device is applied for enabling the operator to use the machine for heavy work by putting hand crank on the drive shaft of machine thereby getting the benefit of the 2:4:1 ratio of gearing between drive shaft and rolls. In seconds the machine can be changed for direct drive on light material by disconnecting the drive shaft and putting the hand crank on the right hand extension of lower roll.

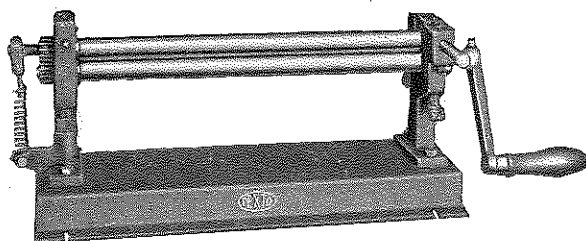
General construction same as on page 22.

Number—Hand drive	390	391	*392
Capacity mild steelgauge	16-18	18-20	20-22
Length of rolls for sheetsins.	36	42	48
Diameter of rollsins.	2½	2½	2½
Ratio of gearing	2.4:1	2.4:1	2.4:1
Shipping weight boxedapprox. lbs.	480	525	575

NOTE:—Floor legs can be furnished at extra cost. Front upper and lower rolls are driven. At an extra cost can be furnished with all three rolls driven. When required motor drive or with pulleys, details will be furnished on request.

TIN PIPE FORMERS

1 INCH AND 1½ INCH ROLLS

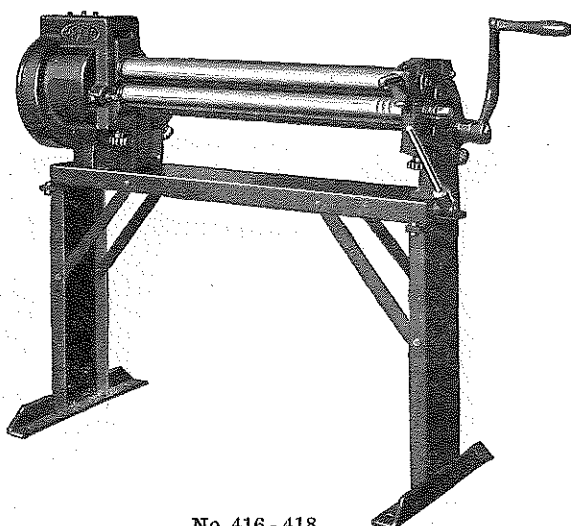


Intended for forming cylinders of small diameters.

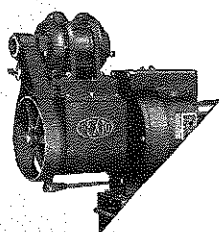
Cylinder when formed the latch then opened permits the upper roll to raise automatically. The formed cylinder can be removed from the roll without distorting it. Latch and roll is released and closed with one movement and is self-locking. Rolls are adjusted with knurled screws. Gears are steel, machine cut.

Number	0350	0384
Length of rolls for sheetswidth ins.	16	20
Diameter of rollsins.	1	1½
Shipped boxedapprox. lbs.	45	95

3 INCH ROLLS



No. 416 - 418



No. 2416 - 2418

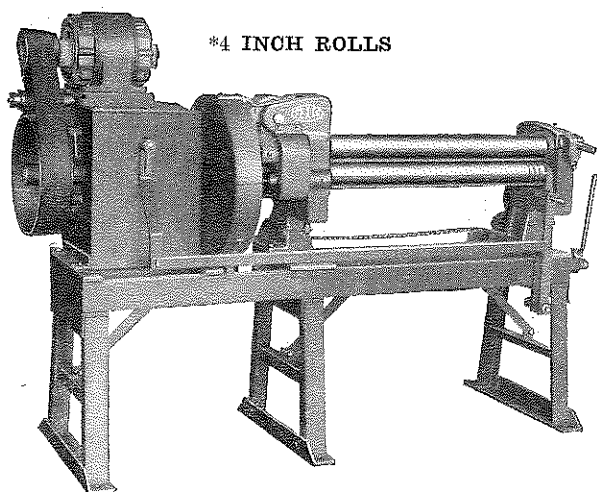
These patterns represent the last word in forming rolls for hand or power operation, embodying such improvements as fully enclosed machine cut steel compensating gears, driven third roll with longitudinal grooves and PEXTO patented top roll raising device. The top roll latch, roll raising lever and crank are on the right hand end of machine. When arranged motor drive double friction clutch for starting, stopping and reversing rolls is operated by convenient hand lever which gives operator full control of machine. Dependable accuracy combined with long wearing qualities and not price govern their sales.

Rolls are adjusted by means of large screws and hand knobs otherwise construction details are same as on page 26.

Number—Hand Drive	416	*417	418
Number—T. & L. Pulley Drive	*0416	*0417	*0418
Number—Dble. Friction Clutch, Belt Dr.	*1416	*1417	*1418
Number—Dble. Friction Clutch, Motor Dr.	*2416	*2417	*2418
Length rolls for sheets	36	42	48
Diameter rolls	3	3	3
Ratio of gearing—power	10:1	10:1	10:1
Ratio of gearing—hand	4:1	4:1	4:1
Capacity mild steel	14-16	15-18	16-18
Speed of rolls	50	50	50
Motor required	$\frac{3}{4}$	$\frac{3}{4}$	$\frac{3}{4}$
Speed of motor	1800	1800	1800
Diameter of motor pulley	3 $\frac{1}{2}$	3 $\frac{1}{2}$	3 $\frac{1}{2}$
Shipping weight crated less floor legs, hand operated	730	770	835
Shipping weight crated, motor drive less motor	925	975	1015

Floor legs furnished when specified at an extra cost.

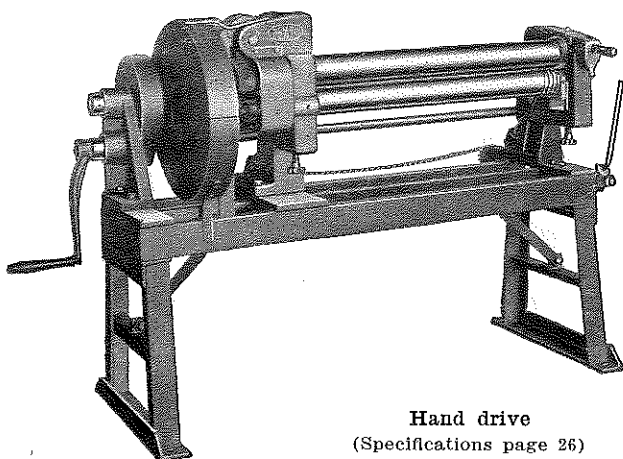
This application of double friction clutch places the machine under full control of the operator. The clutch is controlled through a lever that locks automatically in three positions — forward, neutral and reverse.



***4 INCH ROLLS**

Arranged with double friction clutch and belted motor drive attachment

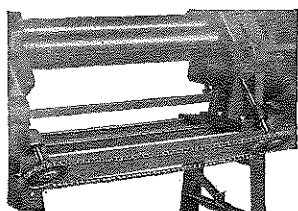
(Specifications pages 26 and 27)



Hand drive

(Specifications page 26)

Section showing sprocket chain for adjusting rear forming roll.



***4 INCH ROLLS**

(Illustrated on page 25)

A new type of Slip Roll Forming Machine priced for its rigid construction embodying worth-while modern features for ease of operation.

All three rolls are driven and the rear forming roll has three longitudinal grooves.

Sprocket chain is provided for the convenient adjustment of the rear or forming roll.

All gears are machine cut and fully enclosed. The driving pinions are steel and the large driving gear is semi-steel.

The lift type of Slip Roll Former, as these new patterns offer, leave free the hands of the operator for the feeding and removal of work.

Ample clearance is provided at left end housing for removing work when formed full length of the rolls.

Lifting of the upper roll is effected through a lever on right end of machine always within easy reach of operator and locks automatically with the roll in tilted position. Simple and very easy to operate.

The rolls need not be stopped when operating the lifting device, a desirable feature especially when arranged power drive, an improvement that merits consideration.

Any weak over-hung parts are eliminated through a patented hinged cap fitted to the right end housing which clamps in one motion and when clamped, it serves as a desirable support making a fully enclosed housing for the upper roll.

The compensating gears always remain in mesh. This permits for ample adjustment of lower roll for clearance so as not to cause the closing of locks previously formed on sheets. Positively no binding of gears while machine is run with upper roll clamped or in tilted position.

Housings are rigidly mounted on steel base. Rolls are high carbon steel smoothly ground and finished and are provided with a series of grooves for forming work that has been previously wired.

External grease cups are provided for idler gears in the gear case.

Number—Hand drive	424	425	426
Length of rolls for sheetswidth ins.	36	42	48
Capacity for soft steelga.	10-12	11-13	12-14
Diameter of rollsins.	4	4	4
Ratio of gearingins.	15:1	15:1	15:1
Floor spaceins.	40x93	40x99	40x105
Shipped on skidsapprox. lbs.	1700	1800	1875

Number—Hand drive	428	430
Length of rolls for sheetswidth ins.	60	72
Capacity for soft steelga.	14-16	16-18
Diameter of rollsins.	4	4
Ratio of gearingins.	15:1	15:1
Floor spaceins.	40x117	40x129
Shipped on skidsapprox. lbs.	2050	2250

NOTE:—Floor legs are included. When required for power drive through double friction clutch order from page 27.

*4 INCH ROLLS

(Illustrated on page 25)

Number—Belted motor drive with double friction clutch					
Length of rolls	ins.	2424	2425	2426	2428 2430
Capacity for soft steel	ga.	10-12	11-13	12-14	14-16 16-18
Diameter of rolls	ins.	4	4	4	4
Ratio of gearing		15:1	15:1	15:1	15:1
Speed of rolls	r.p.m.	25	25	25	25
Speed of drive pulleys	r.p.m.	375	375	375	375
Size of drive pulleys	ins.	16x4	16x4	16x4	16x4
Motor required	h.p.	1	1	1½	2
Speed of motor	r.p.m.	1200	1200	1200	1200
Diameter of motor pulley	ins.	5½	5½	5½	5½
Floor space	ins.	46x90	46x96	46x102	46x114 46x126
Shipped on skids, motor drive, less motor	approx. lbs.	2225	2325	2425	2625 2825

NOTE: Floor legs are regularly furnished with these machines. Belted motor drive arrangement includes motor pulley and belt. Belt guard, motor and control are extra.

*4½ INCH ROLLS

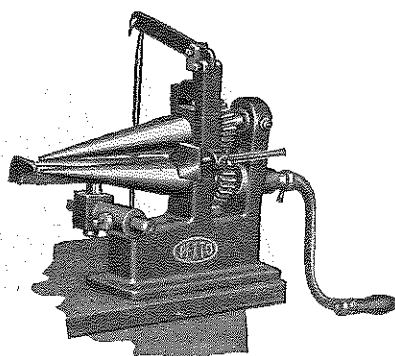
Number—Belted motor drive with double friction clutch			
Length of rolls for sheets	ins.	3404	3405 3406
Capacity for soft steel	ga.	8-10	10-12 12-14
Diameter of rolls	ins.	4½	4½ 4½
Ratio of gearing		15:1	15:1 15:1
Speed of rolls	r.p.m.	25	25 25
Speed of drive pulleys	r.p.m.	375	375 375
Size of drive pulleys	ins.	16x4	16x4 16x4
Motor required	h.p.	1½	2 3
Speed of motor	r.p.m.	1200	1200 1200
Diameter of motor pulley	ins.	5½	5½ 5½
Floor space	ins.	46x90	46x102 46x114
Shipped on skids, motor drive, less motor	approx. lbs.	2325	2525 2725
Length of rolls for sheets	width ins.	3407	3469 3470
Capacity for soft steel	ga.	14-16	20-22 22-24
Diameter of rolls	ins.	4½	4½ 4½
Ratio of gearing		15:1	15:1 15:1
Speed of rolls	r.p.m.	25	25 25
Speed of drive pulleys	r.p.m.	375	375 375
Size of drive pulleys	ins.	16x4	16x4 16x4
Motor required	h.p.	3	5 5
Speed of motor	r.p.m.	1200	1200 1200
Diameter of motor pulley	ins.	5½	5½ 5½
Floor space	ins.	46x126	46x150 46x174
Shipped on skids, motor drive, less motor	approx. lbs.	2925	3325 3725

*5 INCH ROLLS

Number—Belted motor drive with double friction clutch			
Length of rolls for sheets	width ins.	1408	1409 1410
Capacity for soft steel	ga.	6-8	8-10 10-12
Diameter of rolls	ins.	5	5 5
Ratio of gearing		15:1	15:1 15:1
Speed of rolls	r.p.m.	18	18 18
Speed of drive pulleys	r.p.m.	275	275 275
Size of drive pulleys	ins.	24x5	24x5 24x5
Motor required	h.p.	3	3 5
Speed of motor	r.p.m.	1200	1200 1200
Diameter of motor pulley	ins.	6	6 6
Floor space	ins.	61x105	61x107 61x129
Shipped on skids, motor drive, less motor	approx. lbs.	3650	3850 4050
Length of rolls for sheets	width ins.	1411	1471 1472
Capacity for soft steel	ga.	12-14	16-18 18-20
Diameter of rolls	ins.	5	5 5
Ratio of gearing		15:1	15:1 15:1
Speed of rolls	r.p.m.	18	18 18
Speed of drive pulleys	r.p.m.	275	275 275
Size of drive pulleys	ins.	24x5	24x5 24x5
Motor required	h.p.	5	7½ 7½
Speed of motor	r.p.m.	1200	1200 1200
Diameter of motor pulley	ins.	6	6 6
Floor space	ins.	61x141	61x165 61x189
Shipped on skids, motor drive, less motor	approx. lbs.	4450	4650 5050

Details pertaining to rolls, pulley drives and of larger diameters will be given on request.

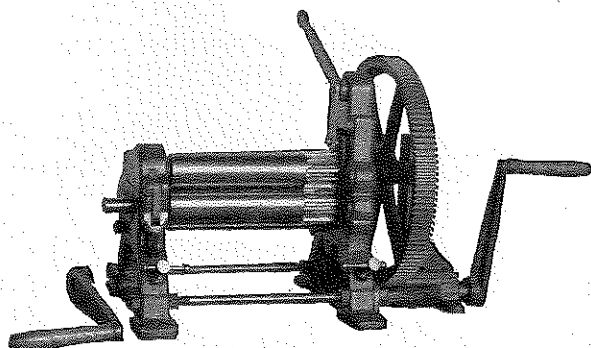
FUNNEL FORMER



For forming conical and taper work of various angles such as can tops, funnels, lamp shades, etc. The third, or forming roll, not shown in cut is adjustable to all positions. The upper roll is depressed by means of foot treadle and can be adjusted for different thicknesses of material. An adjustable gauge is provided for forming work of various lengths.

Number	459
Capacity mild steel	gauge 26
Length of forming rolls	ins. 10
Smallest diameter that can be formed on small end	ins. $\frac{5}{8}$
Smallest diameter that can be formed on large end	ins. 3
Shipped boxed	approx. lbs. 95

SHORT HEAVY SLIP ROLL FORMING MACHINE

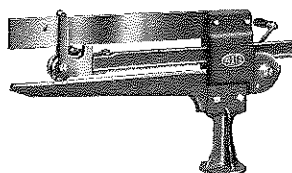


SINGLE BACK GEARED

An extra heavy short Former designed for heavy duty. It is of the slip roll type. The lifting of the upper roll is effected through a hand lever.

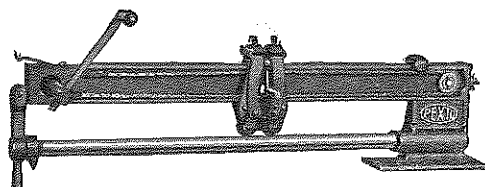
For power drive—details on request.

Number	*414
Capacity mild steel	gauge $\frac{1}{8}$
Length of rolls for sheets, width	ins. 12
Diameter of rolls	ins. 3
Ratio of gearing	10 to 1
Shipped crated	approx. lbs. 450



Number	*502
Capacity mild steel and lighter	gauge 24
Will groove work, length	ins. 20
Size of grooving horn, large end	ins. 3
Size of grooving horn, small end	ins. 1 5/8
Shipped boxed	approx. lbs. 110

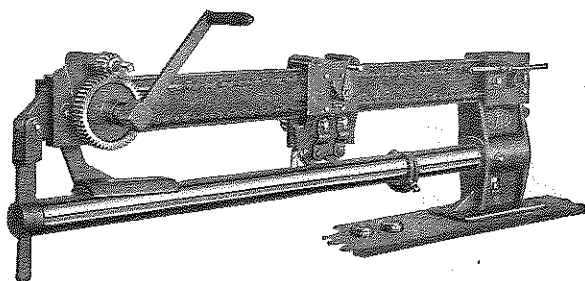
Furnished with three grooving rolls $\frac{1}{16}$, $\frac{1}{4}$, $\frac{5}{16}$ inch.



For grooving or closing longitudinal seams in cylinders after edges of sheet have been prepared on folder and sheet formed into a cylinder on forming rolls. Horn is reversible having one flat surface for outside seams and three grooved surfaces for inside seams. Latch and operating crank are on outer end of machine for quicker and more convenient operation.

Furnished with two flattening rolls and $\frac{1}{4}$, $\frac{5}{16}$, $\frac{3}{8}$ inch grooving rolls. Floor pedestal available at an extra cost.

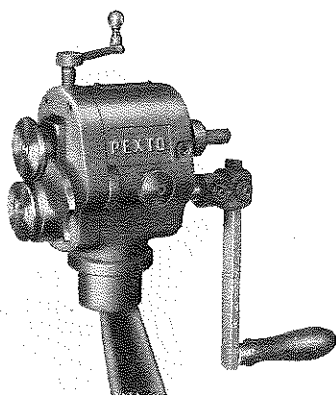
Number	518
Capacity	gauge 22
Will groove work length	ins. 30
Diameter smallest pipe that can be grooved	ins. 2
Shipping weight boxed	lbs. 205



These groovers are back geared for easy operation on the heavier grooving work but crank on hand machine can quickly be placed on large gear shaft for more rapid grooving of light material. On power machines small lever on carriage engages driving chain with adjustable stops provided for automatically stopping carriage at beginning and end of travel. Grooving roll carriage is started by throwing small lever on carriage. Floor pedestal available at an extra cost.

Number—Hand Drive	520	*516	*517
Number—"V" Belt Motor Drive	1520	*1516	*1517
Will groove work in length	ins. 36	42	48
Capacity	gauge 20	22	24
Diameter grooving horn	ins. 3	3	3
Motor requirements—1 1/2 H.P., 1800 R.P.M.			
Linear speed of grooving carriage when arranged motor drive..feet per minute	100	100	100
Motor pulley face	ins. 3 1/2	3 1/2	3 1/2
Shipping weight, boxed, Hand Drive—lbs.	460	475	495

Furnished with two flattening rolls and three grooving rolls $\frac{1}{16}$, $\frac{1}{8}$, and $\frac{1}{4}$ inch.



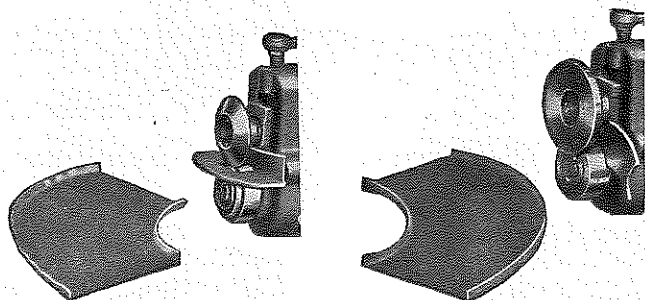
This one improved machine with any of its interchangeable rolls (page 31) will take care of TURNING, BURRING, WIRING, ELBOW EDGING, and FLANGING operations.

A truly "UNIVERSAL" machine and the only one embodying ALL of the following improvements in addition to a positive gauge lock.

Heavy totally enclosed frame, solid steel machine-cut quiet running gears...two-in-one screw gauge with knurled adjusting nut that can be applied to back of machine for burring and wiring operations and to front of machine for turning and elbow edging work...face of gauge polished hardened steel...hardened steel rolls held to key-seated shafts with screw nuts eliminating the necessity of locking gears to remove rolls...forged steel crank for depressing top roll, independent from its screw, that can be placed in any position so as not to interfere with material...spring cushioned journal box and knurled lock nut with set screw for lower roll adjustment...steel crank that can be applied to top shaft for burring and wiring work and to lower shaft for turning, elbow edging and flanging operations, adjustable for short or long leverage for convenience of operator is attached to heavy square end shafts eliminating any possibility of crank slippage.

Number—See page 31

Capacity mild steel	gauge	22
Distance between shaft centers	ins.	2



"L" Flanging Rolls
with Curved Gauge

"M" Flattening
Rolls

See other roll combinations, page 31.

Illustration page 30

(Specify from following numbers)

No. 544—Without rolls but including screw nuts for holding rolls, offset standard and spanner wrench. Rolls on this page and rolls and curved gauge (page 37) are interchangeable. Shipping weight 25 lbs.

No. 1544—With (A) thin turning rolls, (B) thick turning rolls, (C) burring rolls including spare upper burring roll, (D) wiring rolls, offset standard and spanner wrench. Shipping weight 28 lbs.

Elbow Edging Rolls No. 1 will be included only when specified and are furnished at an extra cost.

No. 2544—With (A) thin turning rolls largest wire 11 gauge, (B) thick turning rolls largest wire 7 gauge offset standard and spanner wrench. Shipping weight 26 lbs.

No. 3544—With (C) burring rolls (highest flange $\frac{1}{4}$ inch) including offset standard and spanner wrench. Shipping weight 26 lbs.

No. 4544—With (D) wiring rolls (largest wire 7 gauge), offset standard and spanner wrench. Shipping weight 26 lbs.

No. 5544—With No. 1 elbow edging rolls, offset standard and spanner wrench. Shipping weight 26 lbs.

No. 6544—With (L) 1st operation flanging rolls, special curved gauge, offset standard and spanner wrench. Maximum flange $\frac{3}{8}$ inch. Minimum radius inside curve flat sheet before flanging 3 inch. Shipping weight 28 lbs.

See page 30.

No. 7544—With (M) 2nd operation flange flattening rolls including regular two-in-one gauge, offset standard and spanner wrench. Shipping weight 27 lbs.

See page 30.

2" Rolls

A



B



C

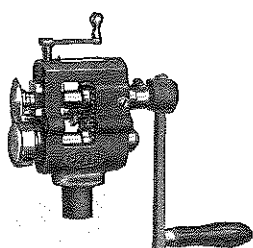


D

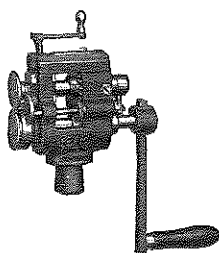


No.
1

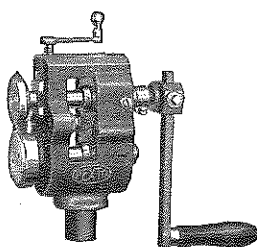




Small
Burring Machine
1½" Rolls



Extra Small
Turning Machine
1½" Rolls



Large
Wiring Machine
3" Rolls

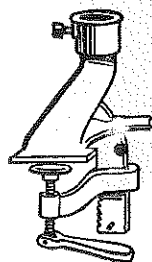
Number	Small Burring 576	Extra Small Turning 540
Capacity	22	22
Diameter rolls	1½	1½
Widest flange or burr that can be turned	⅜	..
Smallest wire that can be usedgauge No.	..	13
Largest wire that can be usedgauge No.	..	11
Shipping weight	26	27
Packed one in a carton		

Number	Large Turning *542	Large Wiring *525
Capacity	22	22
Diameter rolls	3	3
Smallest wire that can be usedgauge No.	9	..
Largest wire that can be usedgauge No.	4	0
Shipping weight	36	36
Packed one in a carton		

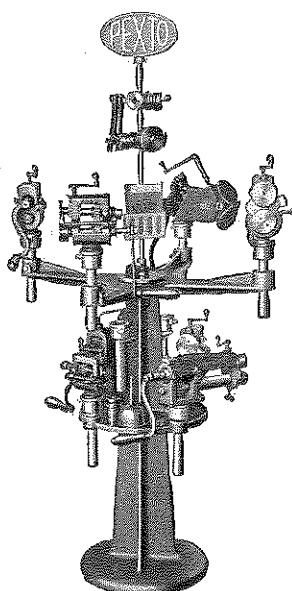
NOTE:—In these machines the rolls are threaded and are screwed on to threaded arbors. Gears are steel, machine cut. Cranks are steel and adjustable. Furnished complete with Standard No. 975.



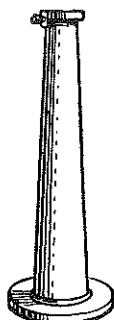
No. 975
Regular Offset
Standard



No. 977
Heavy
Standard



No. 969
Holdall Revolving Machine
Standard



No. 979
Heavy Floor
Standard



No. 984
Light Floor
Standard

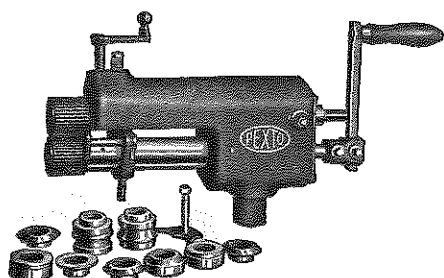
BENCH AND FLOOR STANDARDS

*No. 969 holders are adjustable to any position. Upper turret revolves. Clamp provided to hold turret rigid. A place for everything—Everything in its place. Regularly furnished with ten machine holders. Shipping weight 280 lbs.

NOTE:—Where this Standard is employed the Regular Bench Standards for machines are not required—Save money—Use this Standard and order all small machines less Regular Bench Standards.

Number	975	977
Size hole	1 $\frac{5}{8}$	2 $\frac{1}{4}$
Height over all from bench	9 $\frac{3}{4}$	10 $\frac{1}{4}$
Shipping weight	11	23

Number	*979	*984
Size hole	2 $\frac{1}{4}$ and 2 $\frac{1}{2}$	1 $\frac{5}{8}$
Height over all from floor	39	39
Shipping weight	90	50

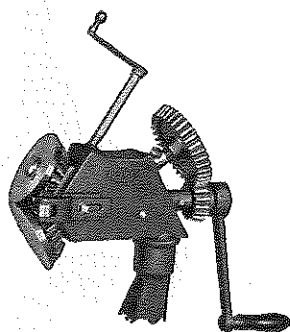


A Deep Throat Combination Machine that will take all the rolls of the No. 544 Combination Machine, page 31, and straight crimping or beading rolls as made for the No. 620 Beading Machine, page 43.

Regularly furnished with 1 pr. each thin turning rolls (A), burring rolls (C), wiring rolls (D), $\frac{3}{4}$ " ogee bead rolls and straight crimping rolls. No. 975 Standard included.

Number	622
Capacity turning, burring, wiring and beading ...gauge	24
Capacity crimpinggauge	26
Depth throat to frameins.	7
Distance between shaft centersins.	2
Shipping weight boxedlbs.	60

SETTING DOWN MACHINES

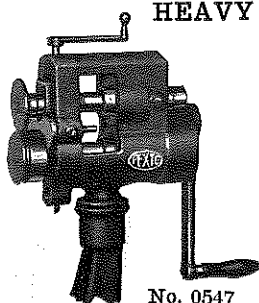


Setting Down Machines squeeze together the flanges on bottoms and bodies of cans, pails, etc. after the flanges are formed on flanging or burring machine and the two sections fitted together.

Also available for power drive. Details on request.

Number	561	562
Capacity mild steelgauge	24	18
For seams up toins.	$\frac{3}{8}$	$\frac{1}{2}$
Shipping weight boxedlbs.	50	90

HEAVY ROTARY MACHINE



No. 0547

Turning capacity—
No. 18 gauge soft steel with $\frac{1}{4}$ or $\frac{1}{8}$ inch wire

No. 20 gauge with $\frac{1}{8}$ inch wire

With burring rolls $\frac{1}{8}$ inch flange or wiring rolls No. 18 gauge

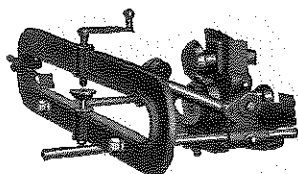
With No. 1 elbow rolls (page 31)
No. 18 gauge

Number	With Turning Rolls	With Wiring Rolls	With Burring Rolls	Combination Machine
	0547	0548	0584	C0547
Diameter rollsins.	3 $\frac{1}{4}$	3 $\frac{1}{4}$	3 $\frac{1}{4}$	3 $\frac{1}{4}$
Ratio of gearing	2:1	2:1	2:1	2:1
Smallest diameter wire that can be usedins.	$\frac{1}{8}$	$\frac{1}{8}$	$\frac{1}{8}$
Largest diameter wire that can be usedins.	$\frac{1}{8}$	$\frac{1}{8}$	$\frac{1}{8}$
Shipped boxed regularly	110	110	110	120
.....approx. lbs.				

NOTE:—Rolls are interchangeable. One pair rolls furnished regularly with Nos. 0547, 0548 and No. 0584 machines. Turning Machines are furnished with turning rolls for $\frac{1}{8}$ inch wire. We can furnish turning rolls for $\frac{1}{4}$ or $\frac{1}{8}$ inch wire. One gauge will work with turning and burring rolls. Extra gauge needed for wiring rolls. No. C0547 Combination Machine regularly furnished with 1 pair each wiring and burring rolls and 1 pair turning rolls for $\frac{1}{8}$ inch wire. Heavy Bench Standard No. 977 furnished regularly. No. 1 elbow rolls (page 31) furnished at extra cost. Apron gauge for elbow rolls extra.

Extra Attachments

Flanging attachments can also be furnished and will be quoted on receipt of information pertaining to required heights of flanges and the smallest and largest diameter of discs to be flanged.



Circle Clamping Attachment for burring discs 5 to 24" dia. Extra.

HEAVY DUTY ROTARY MACHINE

Capacity—

No. 16 ga. soft steel and lighter

Turning capacity—

No. 16 gauge with $\frac{1}{4}$ or $\frac{1}{8}$ inch wire

No. 18 gauge with $\frac{1}{8}$ inch wire

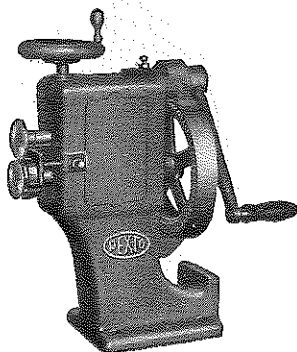
With wiring rolls—

No. 16 gauge $\frac{1}{8}$ to $\frac{1}{16}$ inch wire

With burring rolls $\frac{1}{8}$ inch flange

No. 16 gauge

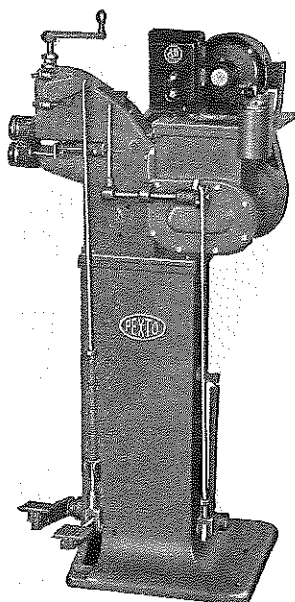
Number	*C532
Diameter of rollsins.	2 $\frac{3}{8}$
Ratio of gearing	4 $\frac{1}{2}$:1
Smallest diameter wire that can be used.....ins.	$\frac{1}{8}$
Largest diameter wire that can be used ...ins.	$\frac{1}{8}$
Shipped crated regularly,weight, approx. lbs.	185



Furnished regularly with turning, wiring and burring rolls.

For bench use but can be furnished with floor pedestal. The frame is solid, the shafts are heavy and bearings are bronze bushed. Pinions are steel, large gear is semi-steel, machine cut.

*Temporarily Discontinued



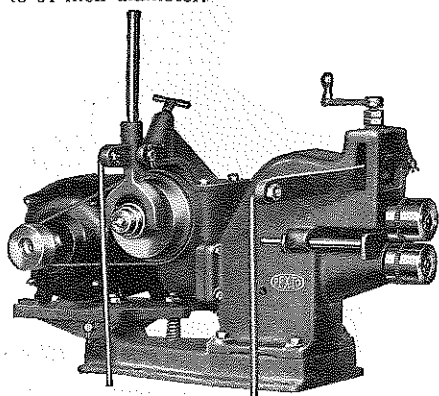
These machines embody many improvements that make them suited for all kinds of roll operations such as burring, turning, wiring, beading, crimping, combined crimping and beading, elbow edging, slitting, flanging, and for the cutting and flanging of circular discs when furnished with circle attachment.

Silent chain drive, variable speeds through quick change of driving sprocket, foot and lever operated friction clutch and hand crank for depressing top roll arbor. Foot treadle for depressing top roll arbor suitable for single operations on light gauge work. Can also be furnished with control for reversing drive. Regularly furnished with one drive sprocket for minimum standard speed. Additional sprockets are extra.

Roll chart pages 38, 39, 40, 41.

Number	1626	1627
Capacity crimping and beading	20	18
Capacity crimping only	18	16
Capacity beading, turning, burring, wiring, elbow edging	18	16
Capacity slitting	16	14
*With circular cutting and flanging attachment (similar to illustration page 35) will cut from square blanks	8 to 24	8 to 24
will flange circular disc up to diameter	8 to 34	8 to 34
Distance between shaft centers	2½	3
Speed of rolls with standard sprockets.....	26-43-64	23-38-47
Depth of throat from end of arbors to frame, ins.	7½	6½
Horse power of motor	½	¾
Shipping weight crated	440	550

*By cutting four corners of square blanks circles can be cut up to 34 inch diameter.



Open and crossed belts for forward and reverse drives and hand and foot operated friction clutch included. Fitted with ¼ h.p. motor single phase 110/220 volts, 10 feet of cord and plug.

Roll chart page 37.

Number	623 for Bench Mounting
Capacity plain crimping	24
Capacity turning, wiring, burring, beading and elbow edging	22
Capacity slitting and trimming	20
Distance between shaft centers	2
Two roll speeds by belt change on pulleys	50 and 75
Depth of Throat from end of arbors to frame	4
Horse power of motor	¼
Shipping weight without floor standard, boxed....	110
Floor standard can be furnished at extra charge.	

ROLL CHART — No. 623 MACHINE

Illustration of Machine and Specifications Page 36

HOW TO ORDER STANDARD ROLLS AND GAUGES

All Rolls are countersunk and held to shafts with screw nuts, making the locking of gears to remove rolls unnecessarily. Rolls are slotted to fit Keyway shafts to prevent roll slippage and for making the frequent changing of rolls easy. **ORDER ROLLS AND GAUGES ACCORDING TO THEIR STOCK NUMBERS.**

	Stock No. of Rolls	Name of Rolls
A	{ 2332 2333	Thin Upper Turning Roll Thin Lower Turning Roll Largest Wire No. 11 Gauge Gauge Stock No. 2440
B	{ 2334 2335	Thick Upper Turning Roll Thick Lower Turning Roll Largest Wire No. 7 Gauge Gauge Stock No. 2440
C	{ 2336 2337	Upper Burring Roll Lower Burring Roll Gauge Stock No. 2441
D	{ 2338 2339	Upper Wiring Roll Lower Wiring Roll Largest Wire No. 7 Gauge Gauge Stock No. 2441
E	{ 2447* 2448*	Upper Straight Crimp Roll Lower Straight Crimp Roll Gauge Stock No. 2442
F	{ 2443* 2444*	Upper Ogee Beading Roll $\frac{3}{4}$ inch Lower Ogee Beading Roll $\frac{3}{4}$ inch Gauge Stock No. 2440 or 2441
G	{ 2450 2451	Upper Single Bead Roll $\frac{1}{4}$ inch Lower Single Bead Roll $\frac{1}{4}$ inch Gauge Stock No. 2440 or 2441
H	{ 2445 2446	Upper Trimming or Slitting Cutter Lower Trimming or Slitting Cutter Gauge Stock No. 2440 or 2441
No. 1	{ 2343 2344	Upper No. 1-V Elbow Edging Roll Lower No. 1-V Elbow Edging Roll Gauge Stock No. 2440
L	{ 2657 2658	Upper 1st Operation Flanging Roll Lower 1st Operation Flanging Roll Gauge Stock No. 2662 and 2663
M	{ 2660 2661	Upper 2nd Operation Flange Straightening Roll Lower 2nd Operation Flange Straightening Roll No Gauge Required







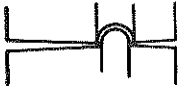
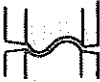


(See Page 30 for Illustration "L" & "M" Rolls)







* When furnished as a Combination Crimping and Beading Machine the machine must be made special. Details on request.

ROLL CHART — No. 162

Where Stock Numbers of Spacing Collars and Gauges depending on assortment

	Name of Rolls	Stock Part No.
	$\frac{5}{8}$ " Turning Rolls	Upper No. 2562 Lower No. 2563
	$\frac{1}{4}$ " Turning Rolls	Upper No. 2564 Lower No. 2565
	$\frac{5}{16}$ " Turning Rolls	Upper No. 2566 Lower No. 2567
	Burring Rolls	Upper No. 2568 Lower No. 2569
	Wiring Rolls	Upper No. 2570 Lower No. 2571
	Slitting Cutters	Upper and Lower Stock Part 2583
	$\frac{3}{8}$ " Single Bead Roll	Upper No. 2603 Lower No. 2604
	$\frac{5}{16}$ " Ogee Rolls	Upper No. 2576 Lower No. 2577

For combined Crimping and Ogee Beading only

	$\frac{1}{4}$ " Pitch Crimping Rolls	Upper No. 2572 Lower No. 2573
	$\frac{5}{8}$ " Pitch Crimping Rolls	Upper No. 2574 Lower No. 2575
	No. 1 Elbow Rolls	Upper No. 2595 Lower No. 2596
	Special No. 2 Elbow Rolls	Special on Application
	Special No. 9 Elbow Rolls	Special on Application
	Special No. 10 Elbow Rolls	Special on Application

When ordering Crimp Rolls the Gauges 2582 and

6 MACHINE — Page 36

d Gauges differ be sure to specify additional
t of Rolls required.









Stock Part No. of Spacing Collars	Gauge Used Part No.	Capacity
Two of Stock Part 2578	Stock Part 2588	No. 18 Gauge
Two of Stock Part 2578	Stock Part 2588	No. 18 Gauge
Two of Stock Part 2578	Stock Part 2588	No. 18 Gauge
Two of Stock Part 2578	Stock Part 2588	Up to $\frac{1}{8}$ " Flange No. 18 Gauge
Two of Stock Part 2578	Stock Part 2588	Up to $\frac{1}{8}$ " Wire No. 18 Gauge
Two of Stock Part 2584	Stock Part 2588	No. 16 Gauge
Two of Stock Part 2579	Stock Part 2588	No. 18 Gauge
Two of Stock Part 2578	Stock Part 2588	No. 18 Gauge

y Spacing Collars are not needed.







Two of Stock Part 2579	Stock Part 2582 See Foot Note	No. 20 Gauge
Two of Stock Part 2579	Stock Part 2582 See Foot Note	No. 18 Gauge
Two of Stock Part 2578	Curved Apron Gauge Stock Part 2605 Special	No. 18 Gauge
Two of Stock Part 2578	Curved Apron Gauge Stock Part 2605 Special	
Two of Stock Part 2578	Curved Apron Gauge Stock Part 2605 Special	
Two of Stock Part 2578	Curved Apron Gauge Stock Part 2605 Special	

i 2588 must be used together.

Where Stock Numbers of Spacing Collars and
Spacing Collars and Gauges depending on assortment

	Name of Rolls	Stock Part No.
	$\frac{1}{8}$ " Turning Rolls	Upper No. 2473 Lower No. 2474
	$\frac{1}{4}$ " Turning Rolls	Upper No. 2475 Lower No. 2476
	$\frac{5}{16}$ " Turning Rolls	Upper No. 2477 Lower No. 2478
	Burring Rolls	Upper No. 2479 Lower No. 2480
	Wiring Rolls	Upper No. 2481 Lower No. 2482
	Slitting Cutters	Upper and Lower Stock Part 2495
	$\frac{1}{2}$ " Single Bead Roll	Upper No. 2614 Lower No. 2615
	$\frac{1}{2}$ " Ogee Rolls	Upper No. 2487 Lower No. 2488

For combined Crimping and Ogee Beading only

	$\frac{1}{4}$ " Pitch Crimping Rolls	Upper No. 2485 Lower No. 2486
	$\frac{5}{16}$ " Pitch Crimping Rolls	Upper No. 2483 Lower No. 2484
	No. 1 Elbow Rolls	Upper No. 2606 Lower No. 2607
	Special No. 2 Elbow Rolls	Special on Application
	Special No. 9 Elbow Rolls	Special on Application
	Special No. 10 Elbow Rolls	Special on Application

When ordering Crimp Rolls the Gauges 2491 and

MACHINE — Page 36

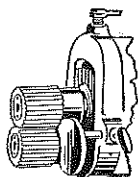
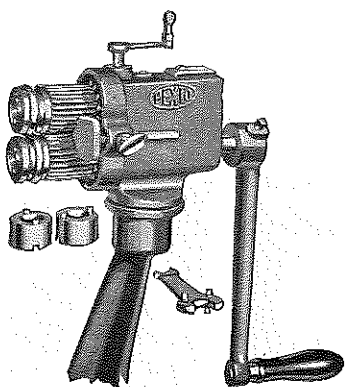
Gauges differ be sure to specify additional of Rolls required.

Stock Part No. of Spacing Collars	Gauge Used Part No.	Capacity
Two of Stock Part 2489	Stock Part 2491	No. 16 Gauge
Two of Stock Part 2489	Stock Part 2491	No. 16 Gauge
Two of Stock Part 2489	Stock Part 2491	No. 16 Gauge
Two of Stock Part 2489	Stock Part 2491	Up to $\frac{1}{8}$ " Flange No. 16 Gauge
Two of Stock Part 2489	Stock Part 2491	Up to $\frac{1}{8}$ " Wire No. 16 Gauge
Two of Stock Part 2496	Stock Part 2491	No. 14 Gauge
Two of Stock Part 2490	Stock Part 2491	No. 16 Gauge
Two of Stock Part 2489	Stock Part 2491	No. 16 Gauge

Spacing Collars are not needed.

Two of Stock Part 2490	Stock Part 2493 See Foot Note	No. 13 Gauge
Two of Stock Part 2490	Stock Part 2493 See Foot Note	No. 16 Gauge
Two of Stock Part 2489	Curved Apron Gauge Stock Part 2616 Special	No. 16 Gauge
Two of Stock Part 2489	Curved Apron Gauge Stock Part 2616 Special	
Two of Stock Part 2489	Curved Apron Gauge Stock Part 2616 Special	
Two of Stock Part 2489	Curved Apron Gauge Stock Part 2616 Special	

2493 must be used together.

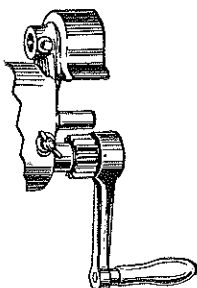
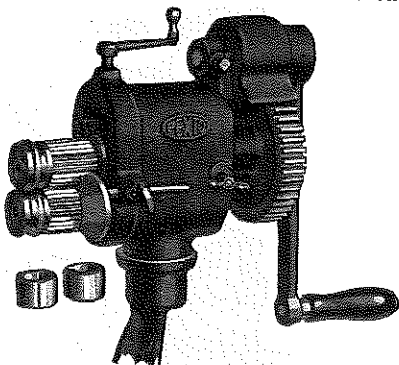
As a Plain
Crimper

Number

Straight Crimp
0581

Capacity soft steel	gauge	24
Shipping weight boxed	lbs.	30

Spiral crimp rolls will be furnished on request.



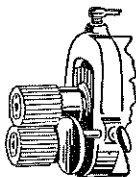
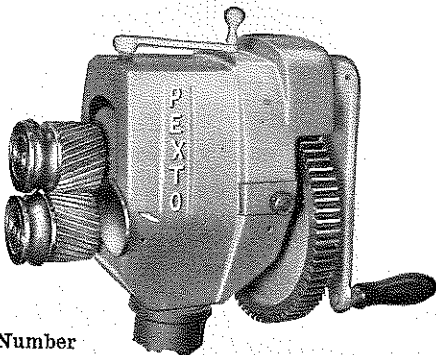
Direct Drive

Number

Straight Crimp
0585

Capacity soft steel	gauge	20
Ratio back gearing		3:1
Shipping weight boxed	lbs.	60

Spiral crimp rolls will be furnished on request.

As a Plain
Crimper

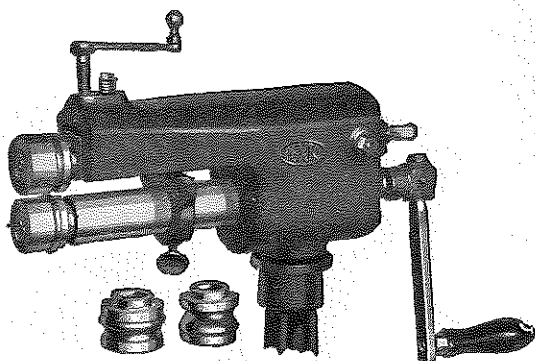
Number

Straight Crimp
0601

Capacity soft steel	gauge	18
Ratio back gearing		4½:1
Shipping weight boxed		125

Spiral crimp rolls will be furnished on request.

No. 975 Bench Standard furnished with No. 0581 and 0585 machines. No. 977 Heavy Bench Standard with No. 0601 machines. PEXTO Interchangeable Crimping and Beading Machines can be used for crimping and beading in one operation or by replacing beading rolls with plain collars, for crimping only. Adjustment is provided for tilting upper shaft to obtain deep or shallow bead and crimp. No. 0585 can be used as direct quick acting machine on light metal by applying crank to lower shaft.



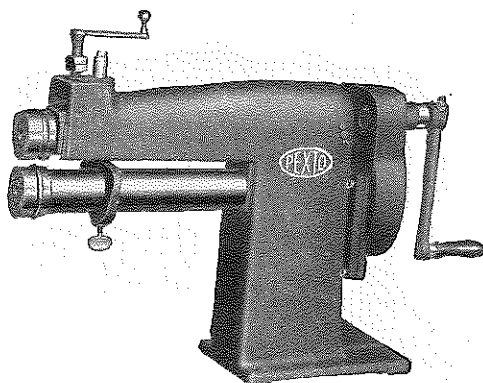
No. 620

No. 619 is constructed with a frame and cap. Rolls are not countersunk. No. 620 has a solid frame with steel horn. Rolls are countersunk.

Crimping rolls and their gauges can be furnished as extra for both numbers.

Furnished with bench standard.

Number	620	*619
Capacity	24	20
Depth of throat to frame	7	7½
Distance between shaft centers	2	2¼
Ratio of gearing	2½ to 1
Single bead rolls regularly furnished	1¼	1
Ogee bead rolls regularly furnished	¾	¾
Shipping weight boxed	55	110



No. 0617

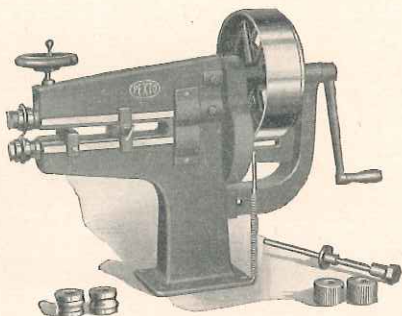
No. 0617 Series Original PEXTO Design Beaders are recommended for beading work as heavy as 18 gauge mild steel.

Back geared with steel horn, bronze bushed bearings, and one-piece frame for bench mounting make them applicable to numerous beading operations in hand and individual motor drive. Can also be equipped with tight pulley and special beading rolls, straight crimping rolls and floor standard. Details on request. When motor driven the drive is same as 1627 machine (page 36) using ¾ h.p. 1800 r.p.m. motor.

Number	Hand 0617	Motor Driven *3617
Capacity	18	18
Depth of throat to frame	13	13
Distance between shaft centers	3	3
Ratio gearing	3½:1	3½:1
Single bead rolls regularly furnished	¾	¾
Ogee bead rolls regularly furnished	1	1
Shipping weight boxed	195	450

INTERCHANGEABLE BEADING MACHINE

The frame and base of this machine is a solid casting and the gearing and arbors are enclosed. A stay clamp is provided to eliminate spring in frame when working up to capacity. Gearing is so arranged for allowing position of the crank to be changed for carrying the work either toward or from the operator with the crank always moving in one direction from the operator. Pinions are steel and large gear is semi-steel machine cut.

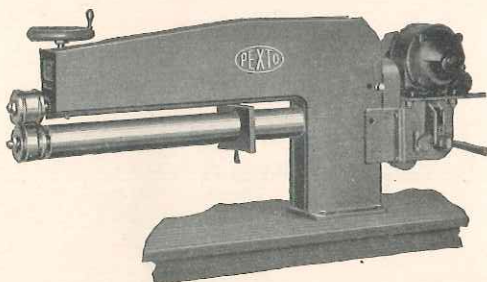


No. 628

Number	Hand *631	Clutch Pulley *628
Capacity	16	16
Depth throat	11	11
Ratio gearing	3 to 1	3 to 1
Diameter beading rolls	2 3/4	2 3/4
Size of pulleys	3x12
Shipped boxed regularly	210	260

NOTE:—Furnished regularly with one pair 1 inch ogee head rolls. Straight crimping rolls, 3/8 inch single bead roll, cutters and collars and guide rest can be furnished at extra cost. Floor pedestal can be furnished at extra cost.

MOTOR DRIVEN EXTRA DEEP THROAT BEADING MACHINE



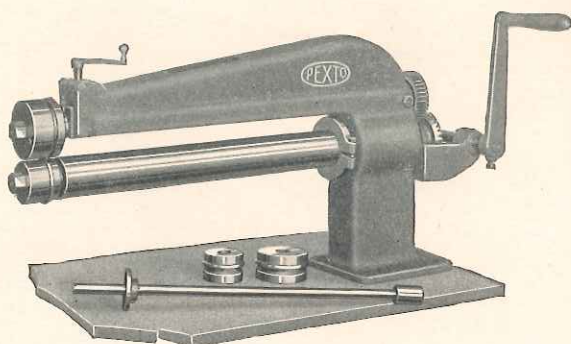
Welded steel construction with bronze bushed bearings. Alemite system for lubrication is employed. The drive from the motor is obtained through silent chain drive with three speed changes by means of interchangeable sprockets. Furnished with single friction clutch controlled by hand lever or foot treadle. Further details on request.

Silent chain motor
drive with double
friction clutch
*629

Number	
Capacity soft steel and lighter	18
Depth of throat from center of rolls to frame	35 1/2
Depth of throat from center of rolls to gauge	34 3/4
Center distance between shafts	4 1/8
For work in diameter as small as	4 1/2
Diameter of arbor in bearings	1 3/4
Diameter of arbor extension for rolls	1 1/2
Length of arbor extension for rolls	3 1/4
Speed of rolls, as may be specified	22-35-44 r.p.m.
Speed of rolls—feet per minute	25-40-50
Horse power required	3/4 h.p.
Speed of motor	1800 r.p.m.
Shipped crated	750 approx. lbs.

NOTE:—Can be furnished with cutters and collars for slitting soft steel full depth of throat capacity 16 gauge. Can also be supplied with special depth of throat on which prices will be quoted on receipt of specifications.

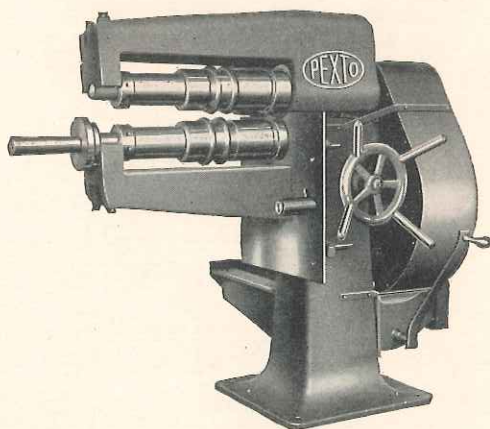
DEEP THROAT BEADING MACHINE



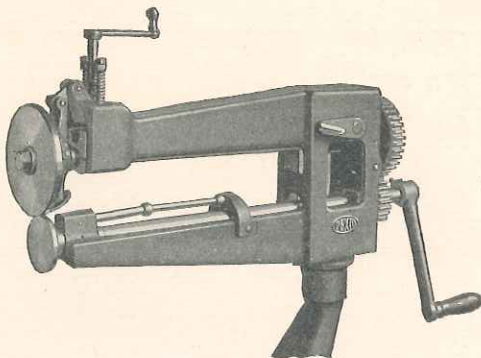
Number	Hand *0664
Capacity mild steel	gauge 20
Diameter lower roll	ins. $3\frac{7}{16}$
Width rolls	ins. $2\frac{1}{2}$
Depth throat	ins. 28
Furnished with single bead rolls	ins. $\frac{1}{2}$
Shipped crated regularly	weight approx. lbs. 420

NOTE:—Can be furnished pulley or motor driven when so ordered. One pair $\frac{1}{2}$ inch single bead rolls are furnished. Special rolls to order. When specified, guide rest for supporting work can be furnished at extra cost.

HEAVY BEADING MACHINES



*The above illustration is representative of our Heavy Beading Machine patterns. Can be furnished with air cylinder, hand wheel or toggle foot treadle for depressing top arbors. The PEXTO Line includes Parallel Shaft and Tilting Shaft Beaders in light, medium and heavy patterns for manual or power operation. Complete details on receipt of specifications



No. 644

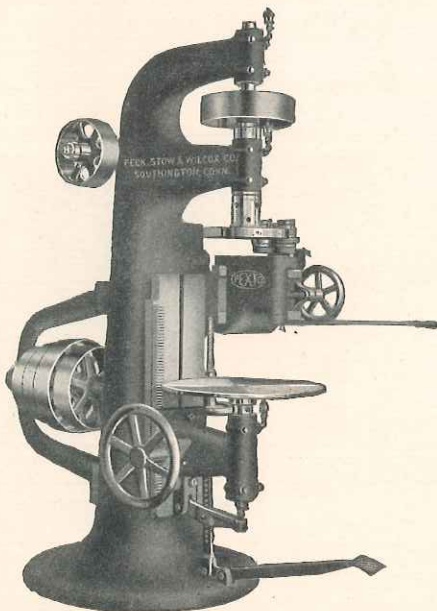
For double seaming flat bottoms on straight or flared cylinder bodies after the bottoms and bodies have been flanged and set down, the Moore's Horizontal Double Seamers have proven practical and economical.

No. 642 is recommended for the heavier gauges and can be furnished in power drive. Frame and base is of one piece for attaching directly to bench.

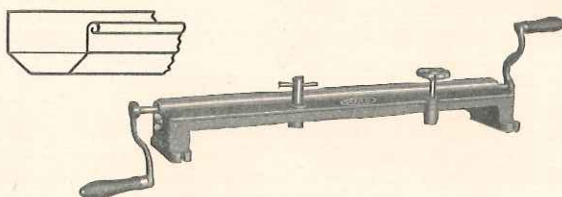
We have patterns for Vertical Seamer hand operated for work 36 in. depth. Details on request.

Number	644	642
Capacity mild steel	gauge 26	20
Maximum depth work	ins. 15½	16
Size lower seaming roll	ins. 2¾	6
Shipping weight	lbs. 110	500

POWER DOUBLE SEAMING MACHINES



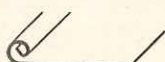
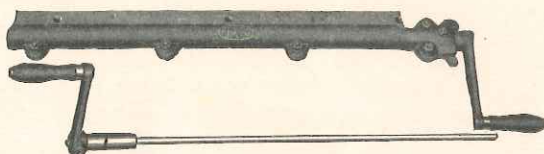
*The PEXTO Line includes complete equipment for manufacturing cans and light drums up to 26 in. diameter and 36 in. high. The above illustration represents one of our Power Double Seamers for double seaming offset tops and bottoms for large production. Details on request.



For forming round bead or edge on sheet metal in making round, ogee or square gutters. Regularly furnished with $\frac{1}{2}$ " rod. Details pertaining to special size rods up to $\frac{7}{8}$ " on request.

Number	*700
Length for sheets.....width, ins.	30
Capacity, mild steel, with $\frac{1}{2}$ inch rod.....gauge	26
Capacity, mild steel, with $\frac{3}{8}$ inch rod.....gauge	26
Capacity, mild steel, with $\frac{5}{8}$ inch rod.....gauge	24
Capacity, mild steel, with $\frac{3}{4}$ inch rod.....gauge	24
Capacity, mild steel, with $\frac{7}{8}$ inch rod.....gauge	24
Shipping weight boxed.....approx. lbs.	75

SINGLE AND DOUBLE LOCK EDGER



Gutter Bead



Single Lock

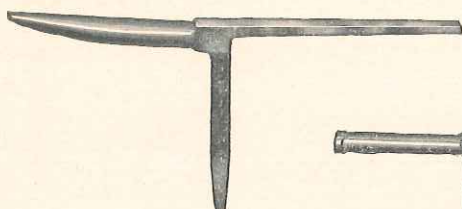


Double Lock

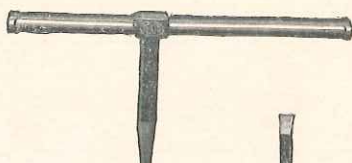
These machines are intended for turning single and double locks on the edges of roofing sheets of light tin. They will form a single or double lock and when furnished with gutter rod, they will do the same work as regular 30-inch gutter beader.

In turning edges a rod with a slot receives the sheet and one movement of the crank turns the edges.

Number	With Edging and Gutter Rod	With Edging Rod less Gutter Rod
	*715	*716
Length	30	30
Capacity	28	28
Diameter gutter rod	$\frac{1}{2}$	
Shipped packed as ordered		
weight	34	29



No. 901



No. 921



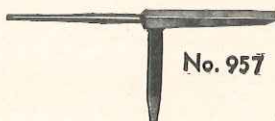
No. 925



No. 953



No. 927



No. 957



No. 956



No. 971



No. 943



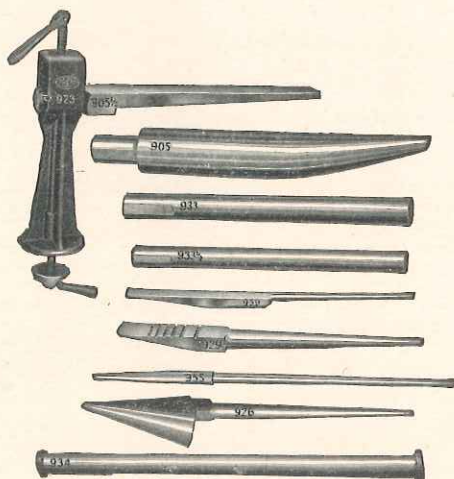
No. 932



No. 935



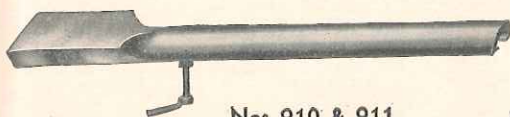
No. 936



No. 964 Set & Holder

CAST STAKES

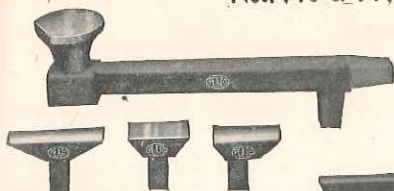
PEXTO



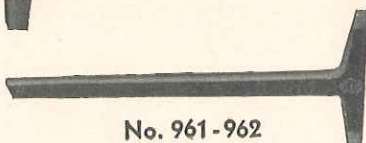
Nos. 910 & 911



No. 965



No. 949 with 4 Heads



No. 961-962

BENCH PLATES

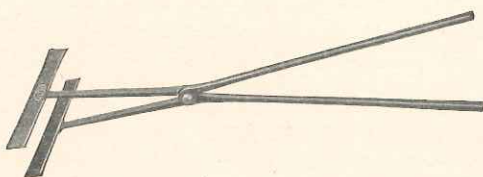


No. 980-982



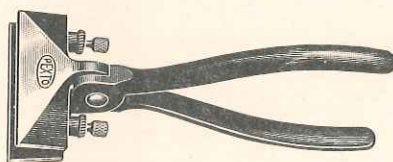
No. 983

No.		Size	Wgt.
901	Beakhorn Stake	38" overall	46 lbs.
910	Hollow Mandrel	40" overall	60 lbs.
911	Hollow Mandrel	60" overall	110 lbs.
921	Double Scaming Stake	29" overall	37 lbs.
925	Blowhorn Stake	27" overall	16 lbs.
927	Creasing Stake with Horn	19" overall	14 lbs.
932	Bevel Edge Square Stake	2¼"x4½" overall	14 lbs.
935	Coppersmiths Square Stake	2½"x4½" overall	11 lbs.
936	Common Square Stake	2½"x4½" overall	11 lbs.
943	Hatchet Stake	13" blade	9½ lbs.
949	Dble. Smg. Stake with 4 Heads	30½" overall	95 lbs.
953	Bottom Stake	1½" blade	2 lbs.
956	Candle Mould Stake	28" overall	7½ lbs.
957	Needle Case Stake	18½" overall	4 lbs.
961	Solid Mandrel Stake	34½" to standard	56 lbs.
*962	Solid Mandrel Stake	30" to standard	43 lbs.
964	Universal Holder and Stakes	(one set)	170 lbs.
965	Round Head Stake	3" dia. head	9½ lbs.
971	Conductor Stake	28" overall	28 lbs.
*980	Bench Plate or Stake Holder	48"x12"	105 lbs.
981	Bench Plate or Stake Holder	37½"x8"	65 lbs.
982	Bench Plate or Stake Holder	30"x8"	42 lbs.
*983	Revolving Bench Plate	8¾"x8¾"	20 lbs.

GUTTER TONGS


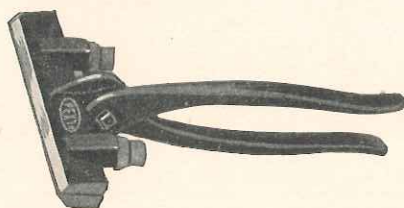
Number	777
Depth jaws	ins 14
Length blades	ins. 12½
Weight each	lbs. 10

Gutter Tongs have deep jaws for making wide bends in sheet metal as in roof gutters and valleys. PEXTO Gutter Tongs have forged steel handles with welded spring steel blades.

HANDY SEAMER


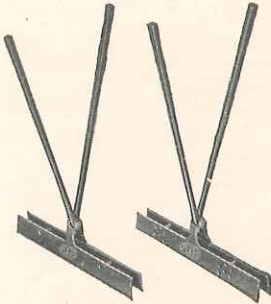
No. 793

Length of blade 3½ inches. Length overall 8 inches. Gauging range ¼ to 1 inch. Weight 1 lb. Black handles. Polished blades. Forged steel.

HANDY SEAMER


Number	795
Length of blade	ins. 6¾
Width of blade	ins. 1½
Size over all	ins. 10¾
Adjustable for seams of different widths up to	ins. 1
Weight each	3

ROOFING TONGS



No. 771 Common Tongs No. 773 Adjustable Tongs

Roofing Tongs are used for bending the edges of sheet metal to a 90 degree angle in preparing metal for a standing double seam. Common Roofing Tongs have riveted pin gauges for one size bend. Adjustable Pin Roofing Tongs No. 773 have threaded pin that can be placed in seven threaded holes for 1/2" to 1 3/4" bends. Blades are 18 1/2 inches long and welded to forged steel handles.

Number	*770 3/4	*771	*771 1/4
Will turn edgeins.	3/4	1	1 1/4
Weight eachlbs.	9	9	9

Number	*771 1/2	*771 3/4	773
Will turn edgeins.	1 1/2	1 3/4	1/2 to 1 3/4
Weight eachlbs.	10	10	10

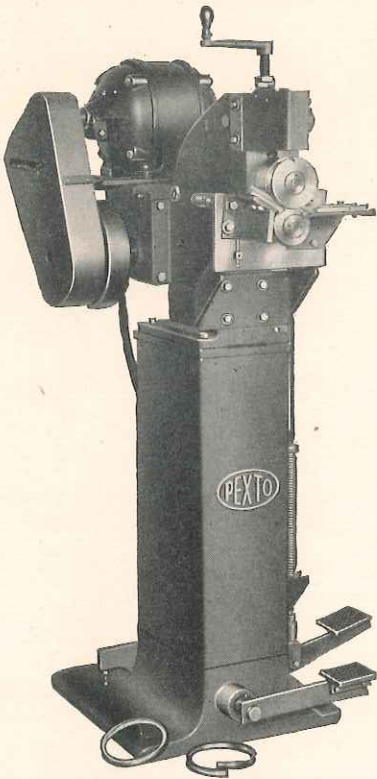
HAND ROOFING DOUBLE SEAMERS



Hand Seamers are used for finishing standing seam after the edges of sheets have been turned to 90 degree angle with roofing tongs. Usually sold in sets of two. High side of tool is used to back up metal while wooden mallet bends metal and finishes seam. Low side is then used for second bending operation and for finishing double seam.

Number	Common Gauge 744	Wide Gauge 745	Iron Gauge *746
Sizesins.	3/4 x 1	1 x 1 1/4	1 1/4 x 1 1/2
Weight per setlbs.	16	19	22
Match up with roofing tongsins.	1 x 1 1/4	1 1/4 x 1 1/2	1 1/2 x 1 3/4

Shipped in sets of two seamers unless otherwise specified.



Standard Electric Rotary Machine fitted with special rolls, table guide and forming shoe for shaping flat strips and forming into various circle diameters in one pass. Typical of many special machines designed by PEXTO.

STEEL STRAIGHT EDGES



These Straight Edges are made of steel and have beveled edges. They are invaluable around the shop for laying out work in general.

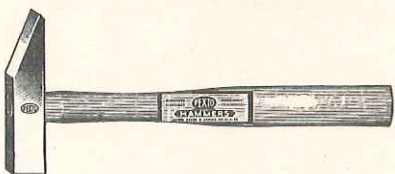
Number	994	995	0995
Length	48	96	120
Size	2½ x 1⅝	2½ x 1⅝	2½ x 1⅝
Shipping weight boxed	15	30	40

RIVETING HAMMERS



Number	2	3	4
Size face	1	$\frac{7}{8}$	$\frac{3}{4}$
Weight each	16	12	8
Length head	$5\frac{1}{4}$	$5\frac{1}{4}$	$4\frac{1}{8}$

SETTING HAMMERS



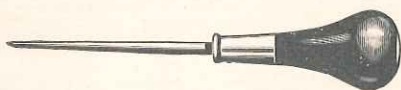
Number—Square Face	3
Size face	$\frac{7}{8}$
Weight each	12
Length head	$4\frac{3}{4}$

RAISING HAMMERS



Number	4
Size faces	$1\frac{3}{16} \times 1\frac{7}{16}$
Weight each	28

SCRATCH AWLS



Steel blade has sharp point and shank goes through wood handle reinforcing its top. Polished shank and steel ferrule.

Number	22
Length of blade	$3\frac{1}{2}$
Length overall	$6\frac{1}{2}$
Weight per dozen	$2\frac{1}{4}$

RIVET SETS

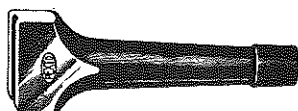


No. 46 Forged Steel

Size	00	0	1	2	3
For iron rivetslbs.	14-16	10-12	7-8	6	4-5
Size holeins.	$\frac{1}{8}$	$\frac{3}{8}$	$\frac{1}{2}$.2130	.1910

Size	4	5	6	7	8
For iron rivetslbs.	3-3½	2-2½	1½-1¾	1-1½	10-12 oz.
Size holeins.	.1660	.1495	.1405	.1285	.1100

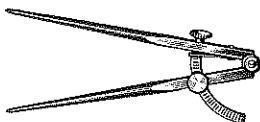
HAND GROOVERS



Forged Steel — Polished Head

Number	0	2	4
Size grooveins.	$\frac{3}{8}$	$\frac{1}{2}$	$\frac{7}{8}$

WING DIVIDERS



No. 35

Forged steel. Polished. Hardened points.

Sizeins.	6	8	10
Weight per dozenlbs.	3½	4½	8

SOLID PUNCHES

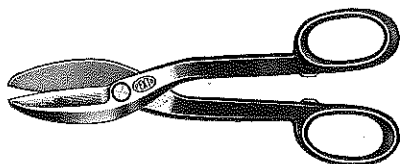


Number	DD88	DD44
Size facedia. ins.	.305	.128
Lengthins.	6	4½
For rivetslbs.	16	1¼, 1½, 1¾

PRICK PUNCH

Number	DD11
Lengthins.	5

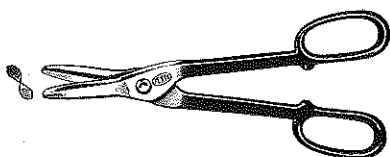
SNIPS — STRAIGHT PATTERN



Forged steel, black handles and polished heads.
Steel laid blades.

Number	9	10
Length of cut	ins. 3	2½
Length overall	ins. 12½	11½
Weight each	lbs. 1¾	1½

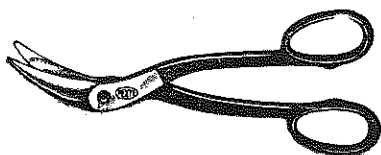
TROJAN SCROLL PATTERN



Forged steel, blue handles and polished heads.

Number	81
Length of cut	ins. 3
Length overall	ins. 13
Weight each	lbs. 2¼

HAWK'S BILL SCROLL PATTERN



Forged steel, blue handles and polished heads. Blades have inside clearance with convex sides. Position of bows above metal when cutting allow for inside and outside scroll shearing.

Number	15
Length cut	ins. 2½
Length overall	ins. 11½
Weight each	lbs. 1¼

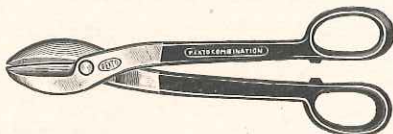
DOUBLE CUTTING SHEARS



Handles malleable iron, blade forged steel, hardened cutting edges, for cutting light gauge pipe. Black handles and polished head.

Number		2A
Length overallins.	12 $\frac{3}{4}$
Weight eachlbs.	3

BULL DOG SNIPS



A heavy forged steel snip for cutting the heavier gauges of steel. Combination Pattern.

Number		414
Length of cutins.	2 $\frac{1}{2}$
Length overallins.	16
Weight eachlbs.	4

TINNERS' BENCH SHEARS

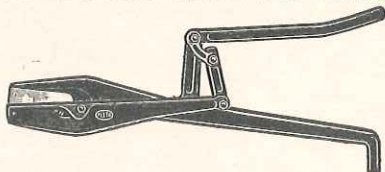


Finish—Black handles and polished heads.

As regularly made, bench shears have a right hand cut with the lower blade on the right side of the shear.

Number		1
Will cut irongauge	18
Length of cutins.	9
Length over allins.	39
Weight eachlbs.	24

COMPOUND LEVER SHEARS



A high grade shear for heavy work. Body is malleable iron; blades high grade steel properly hardened and tempered. Blades are removable, therefore can be replaced. Black handles, polished blades.

Number		44
Capacity mild steelgauge	12
Length of cutins.	4
Length overallins.	34 $\frac{1}{4}$
Weight eachlbs.	21

